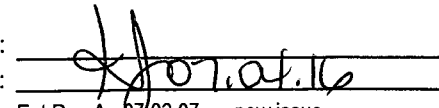
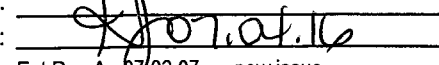


Date: Monday, 4/16/2007 2:26:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number : 31770	
Estimate Number : 12779	
P.O. Number : N/A	Part Number : D350600242
This Issue : 4/16/2007 S.O. No. : N/A	Drawing Number : D3188REV.E, ICA REV. 2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : E, 2
Previous Run : 31769	Material : N/A
Written By : 	Due Date : 5/10/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est Rev: A 07.03.07 new issue EC	
est rev B 07.04.16 reformat, D3188 rev.E EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



w/o 30043 / 30033



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

KS 07.05.01

①

2.0 31770A

SPACEPOD BODY RH



w/o 30043



Comment: Sub-Component SPACEPOD BODY RH

ml07/05/01

3.0 31770B

SPACEPOD DOOR RH



w/o 30033



Comment: Sub-Component SPACEPOD DOOR RH

ml07/05/01

4.0 D31872

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-2	Floor	B25405
1	D3186-4	Door (ref)	N/A
1	D3188-2	Body(ref)	N/A

✓

ml07/05/02

5A

ALS41032130 ALS71032130

Insert

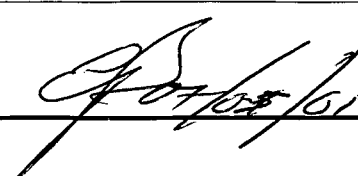


PTO

Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: M102776



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector
07/05/01	S.B	Permanent Change. Missing parts on <u>R/H</u> only 8X AN 3235-020-935 # B M103962	ml	07/05/01		<i>[Signature]</i> 07-05-07	<i>[Signature]</i> 07/05/07
	S.C	Permanent Change Missing Washer AN 960 JDS16 m103641 x1 (for ball stud)	ml	07/05/01		<i>[Signature]</i> 07-05-07	<i>[Signature]</i> 07/05/07

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

ml 07/05/02

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/02

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

m. k 07/05/02

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****D3187-1 floor only*****

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

HL 07-05-02 (1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/05/03

11.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

neoprene foam

batch: *B 30632*

✓ ml 07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml 07/05/02

13.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

N/A ml 07/05/02

14.0	D30153	Lock Nut
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: *B30169-*

15.0	D35547	BALL STUD
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

B 30210-

16.0	D35672	DECAL
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: *B31128-*

17.0	D2237	Striker Plate
------	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: *D30680-*

18.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: *D30159-*

07/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B30866

20.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B21490

21.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M103574

22.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M103492

23.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M15003

CP 07/05/01

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

****This step separates hardware, previous steps is for body & floor****

N/A ml 07/05/02

25.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585

CP 07/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

26.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: M103492-

27.0	NAS1515H3	Washer
------	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: B100993-

28.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: M15003-

29.0	D2464	3/4 Seal
------	-------	----------



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)
3/4 Seal
Cut 127.00" long batch: B30681-

30.0	D35672	DECAL
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: B31128-

31.0	D2586	Door Latch
------	-------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Door Latch
batch: B29021-

32.0	D2585	Latch Clamp
------	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Clamp
batch: B30814-

[Handwritten Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: B29995-

34.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M18057-

35.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100743-

36.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M104215-

37.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B31741 B26209-

38.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B31791-

39.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: B30679-

Handwritten signature/initials

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M103585

41.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M103492

42.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M105003

43.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: ~~M105003~~ B31126

44.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M79216

45.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585

46.0

SMALL FAB 1.

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Hysol batch: M103722 expire date: march 2008
A/R Milled fibres batch: M100859

> ml 07/05/03

2-Attach Neoprene Foam to floor using Contact Cement
A/R Contact Cement Batch: M102565

> ml 07/05/07

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/05/07

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk-Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4
Batch: M103707

m-l 07/05/07

49.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

ml 07/05/07

50.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total: 1.0000 (s)

D31842 ✓

51.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

52.0

D350600449

SWITCH RELOCATION KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
SWITCH RELOCATION KIT

D31898 ✓

53.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Label

batch:

B27863 ✓

7-15/950

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:26:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B31124 ✓

55.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: B31148 ✓

56.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B31149 ✓

57.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210 ✓

58.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M11989 ✓

59.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B22365 ✓

60.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: B

PPP Rev: B

2/5/9 SP

EPB/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 07/05/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:27:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31770

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

67105108 ①

Job Completion



67105108

QCY

inspected as per 100% per completion

67105108

67105108 ①

3187-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

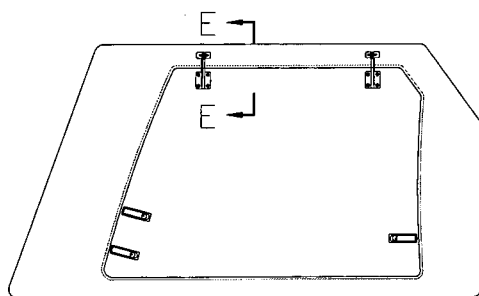


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

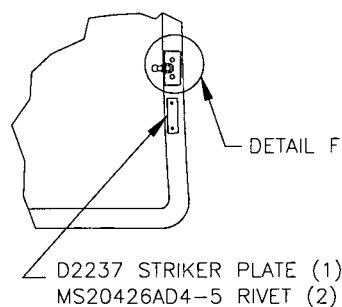


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

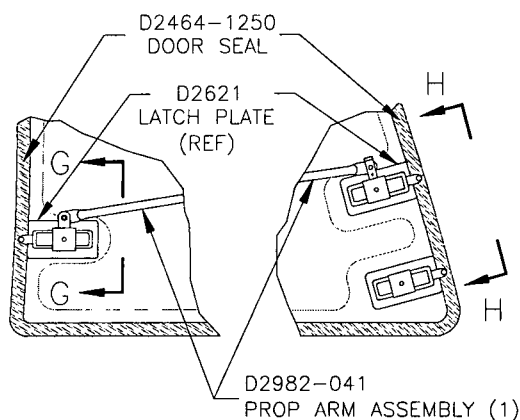
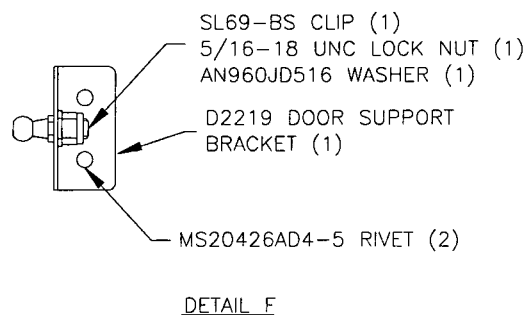


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



TC Accepted

MAY 07 2003

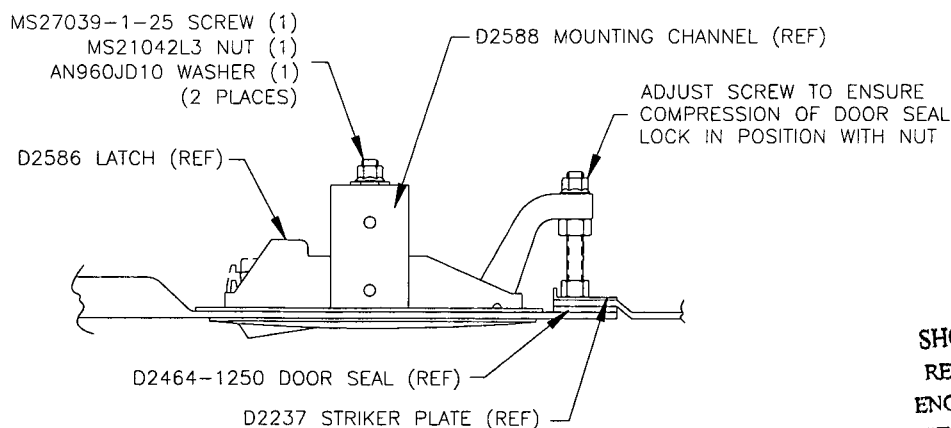
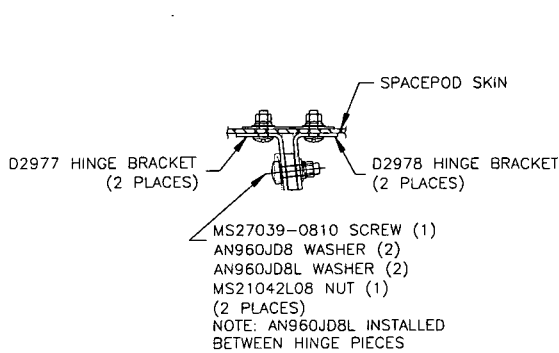


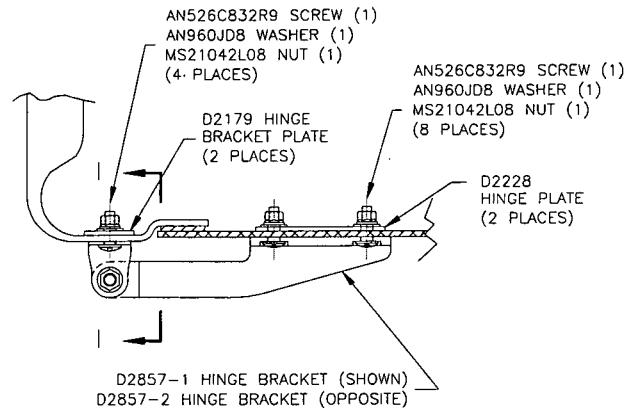
FIGURE 6. TYPICAL LATCH INSTALLATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER 31770

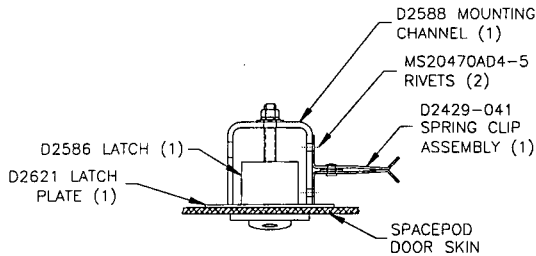
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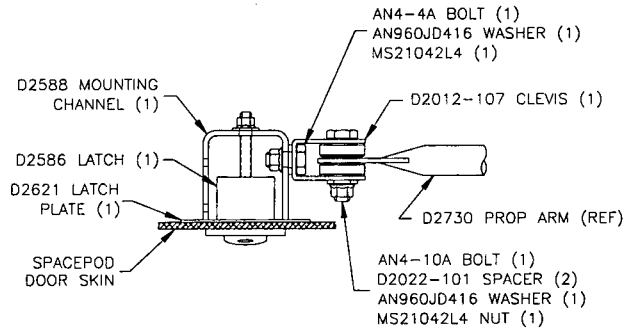
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



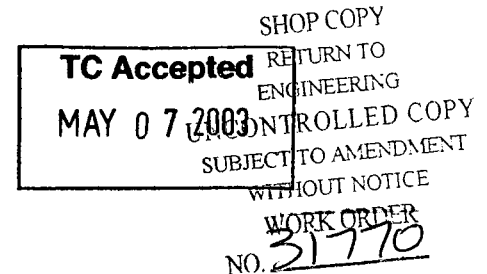
SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.



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25-00-00

DART

RELEASED

07.04.02

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	CE	APPROVED	[Signature]	DRAWING NO. D3188	SHEET 1 OF 11
DATE	07.04.02	TITLE	SPACEPOD BODY	SCALE	NTS
A	03.04.03	NEW ISSUE			
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7			
C	06.12.13	REMOVED D0600-XXX LABELS			
D	07.02.22	UPDATE DIMENSIONS			
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11			

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

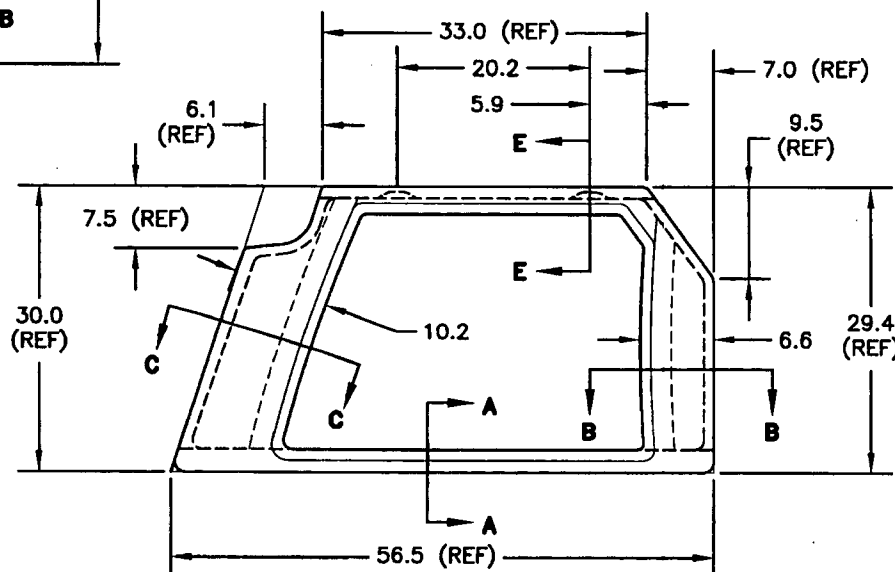
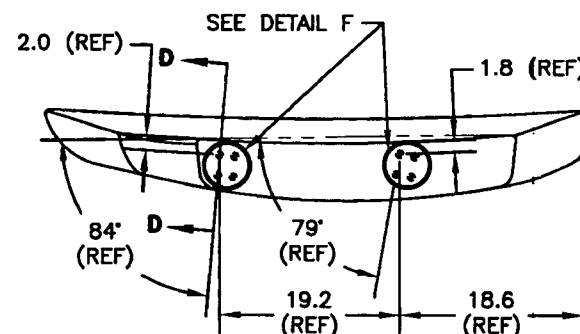
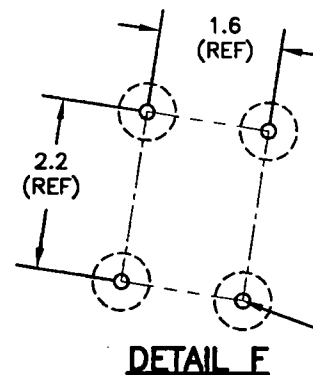
NO. 31770
WORK ORDER
ATTN: OFFICE
SUBJECT: ADVISORY
INCIDENT DILLID COPY
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RETURN TO
RECORDS

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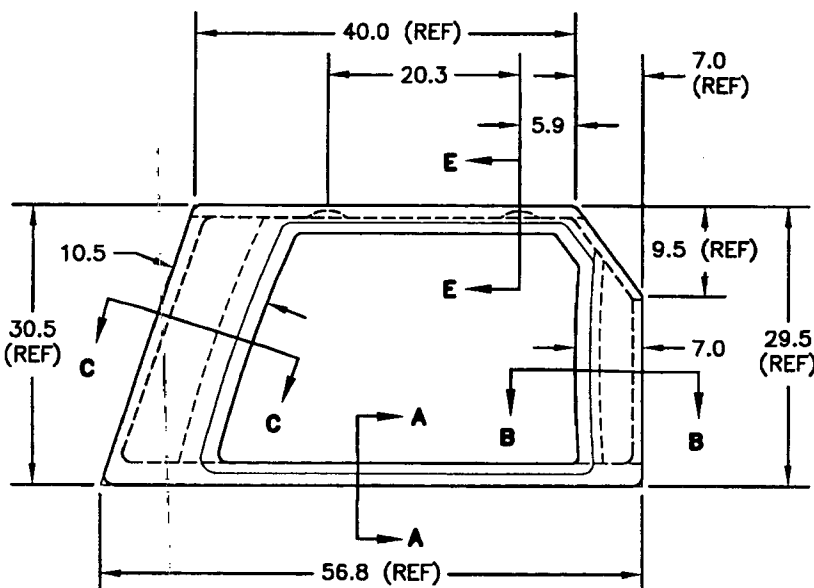
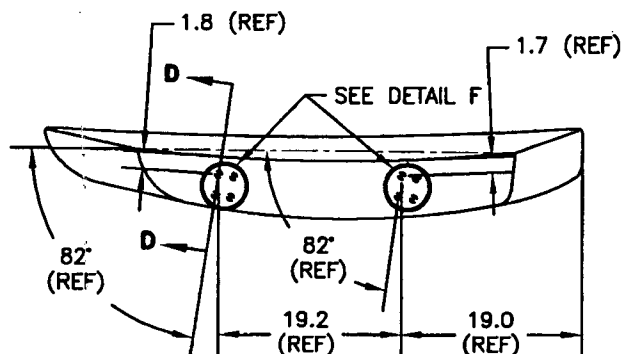
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CHECKED	CE	APPROVED	[Signature]	DRAWING NO.	D3188
DATE	07.04.02	TITLE	SPACEPOD BODY	REV. E	SHEET 2 OF 11
				SCALE	NTS

RELEASED
07-04-01

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

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NO. 31770

D3186-1M/-3M NOTES:

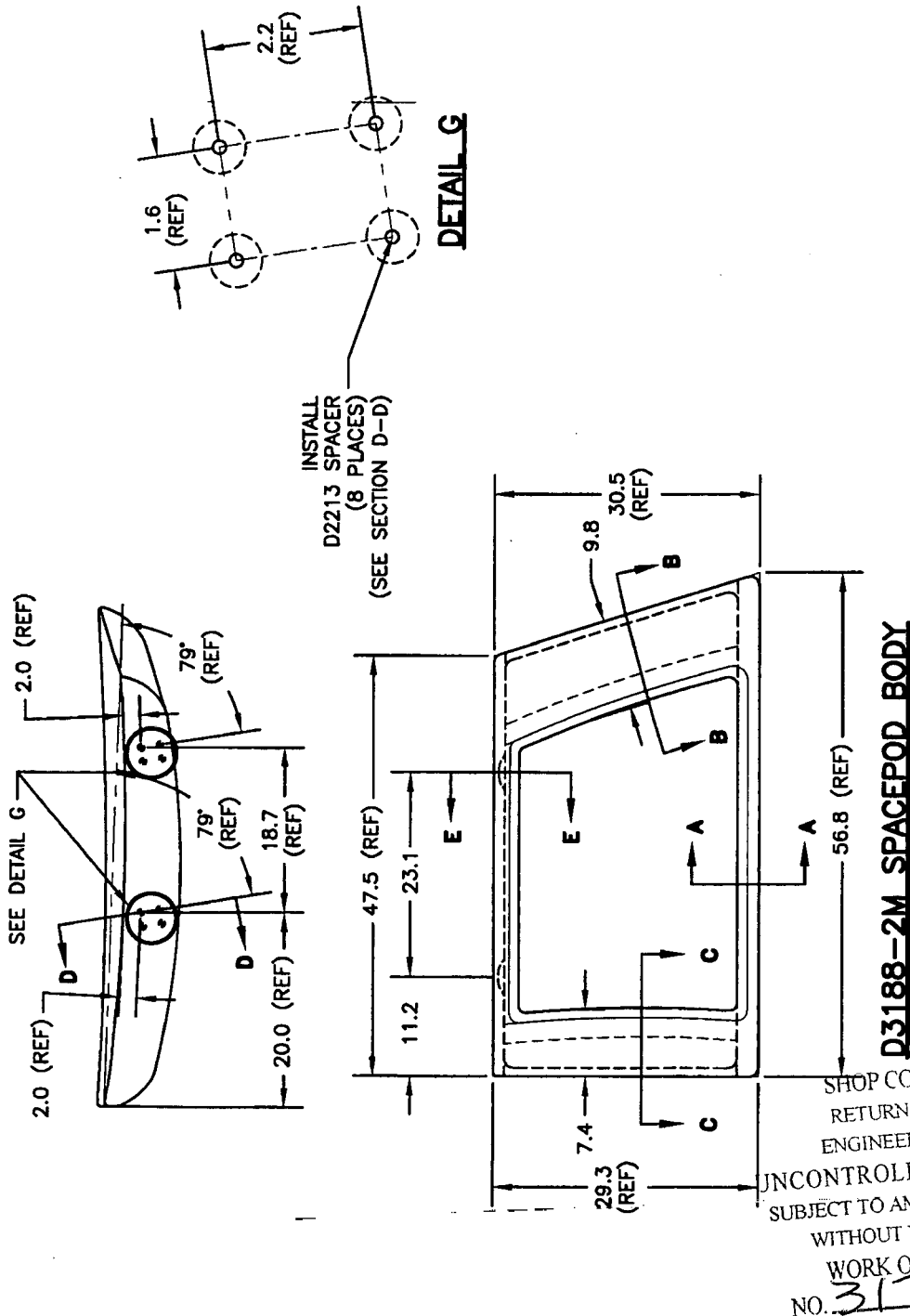
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

DART

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02 **[Signature]**



D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

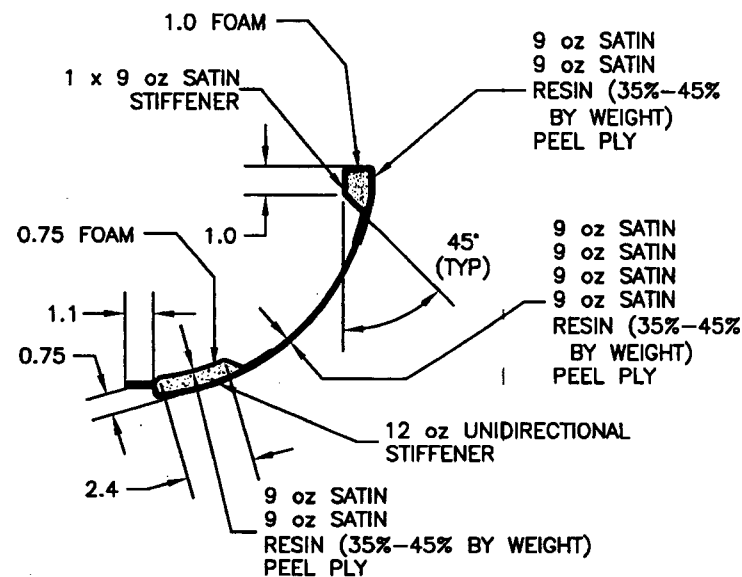
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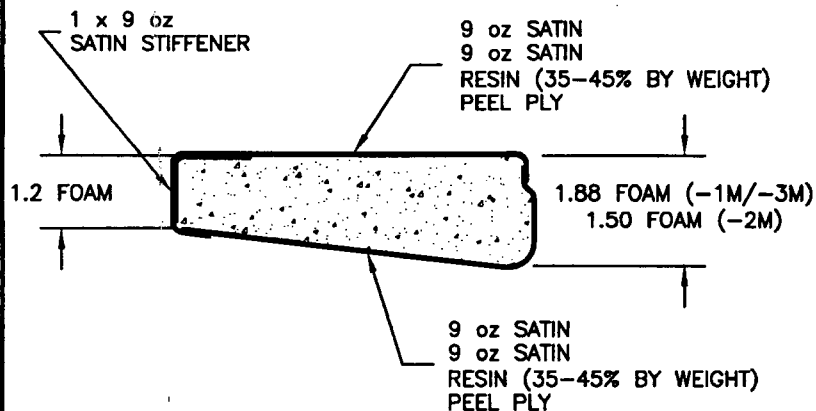
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

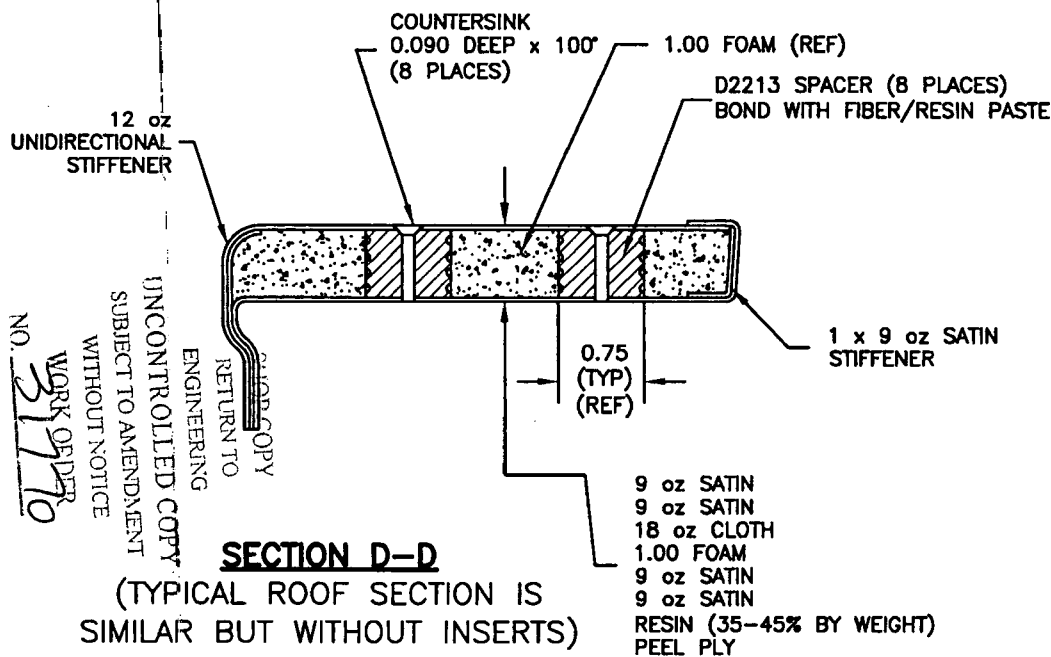
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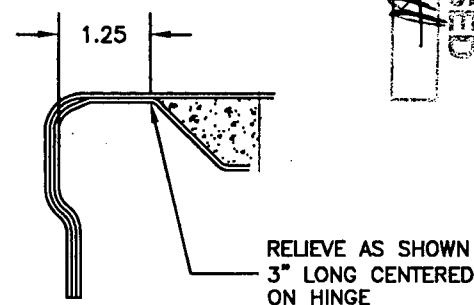
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



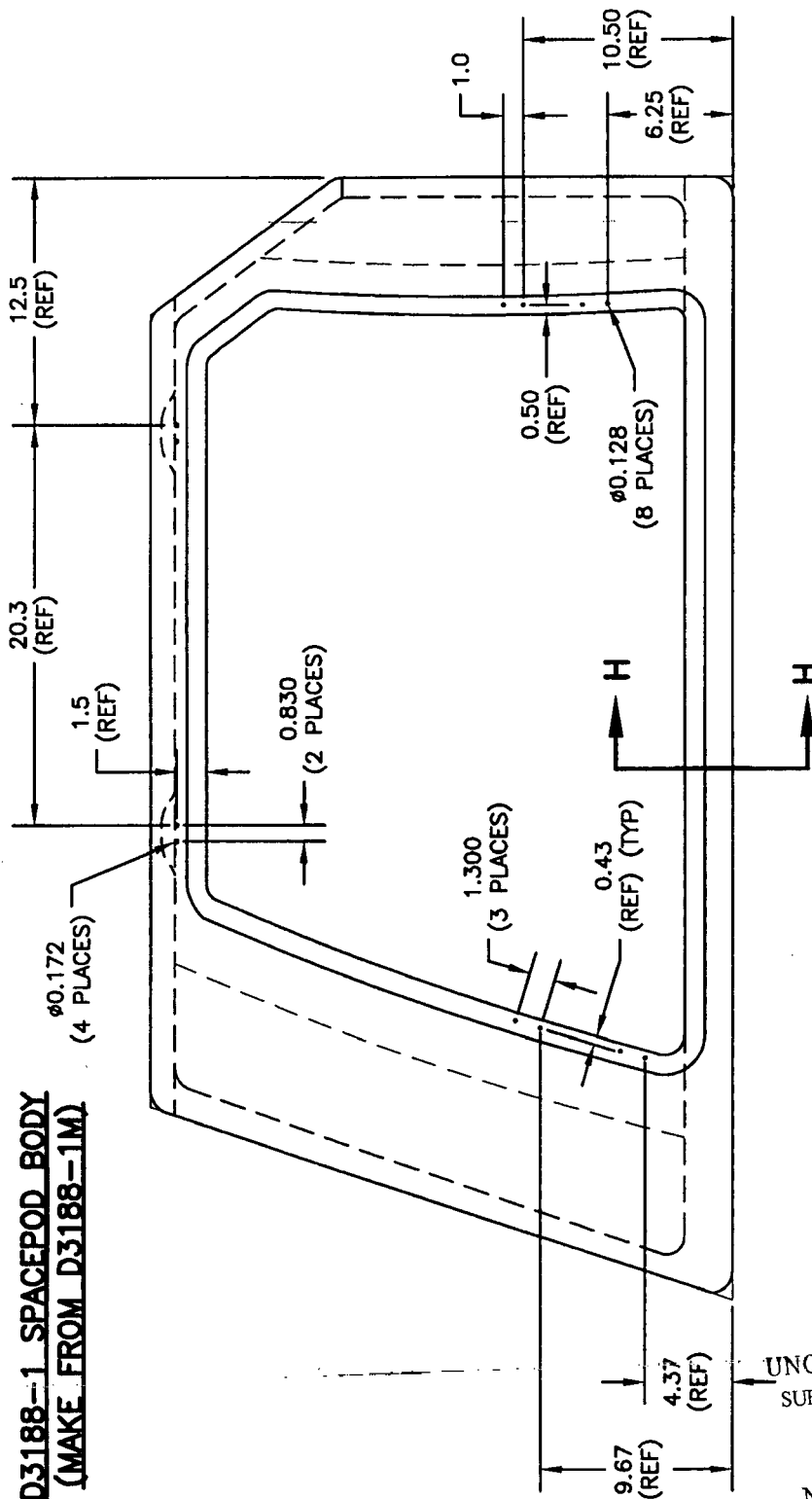
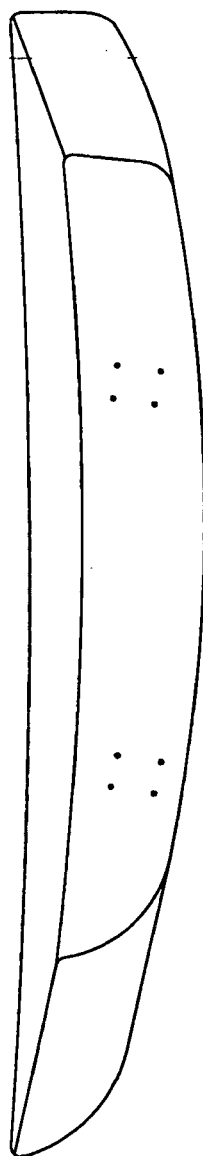
SECTION E-E
(2 PLACES PER POD)

DART

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DATE 07.04.02	TITLE SPACEPOD BODY	REV. E SHEET 5 OF 11 SCALE NTS

RELEASED

07.04.02



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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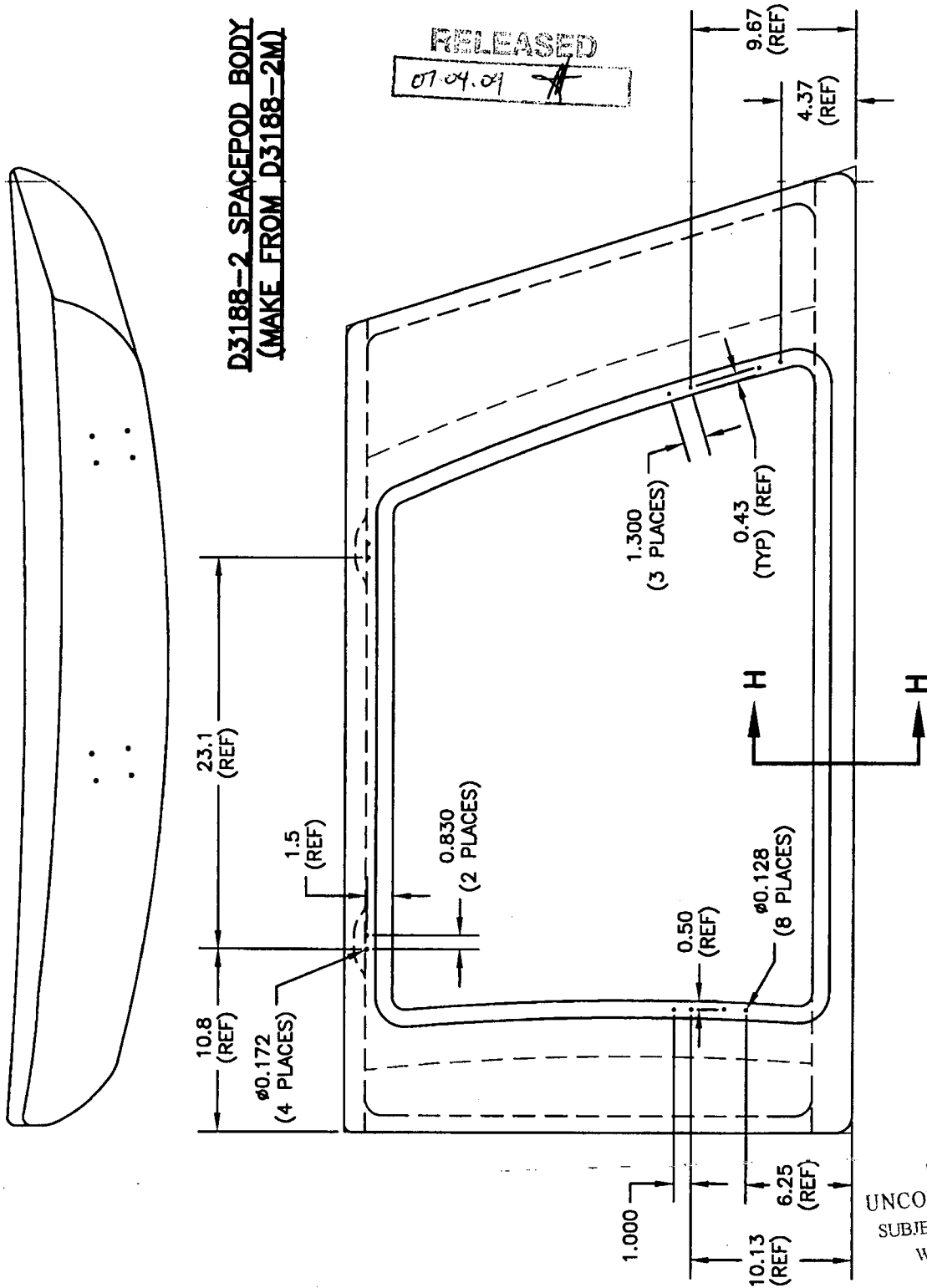
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NO. **31770**

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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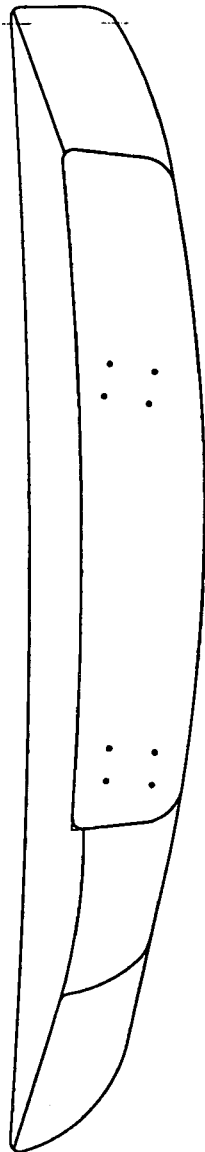
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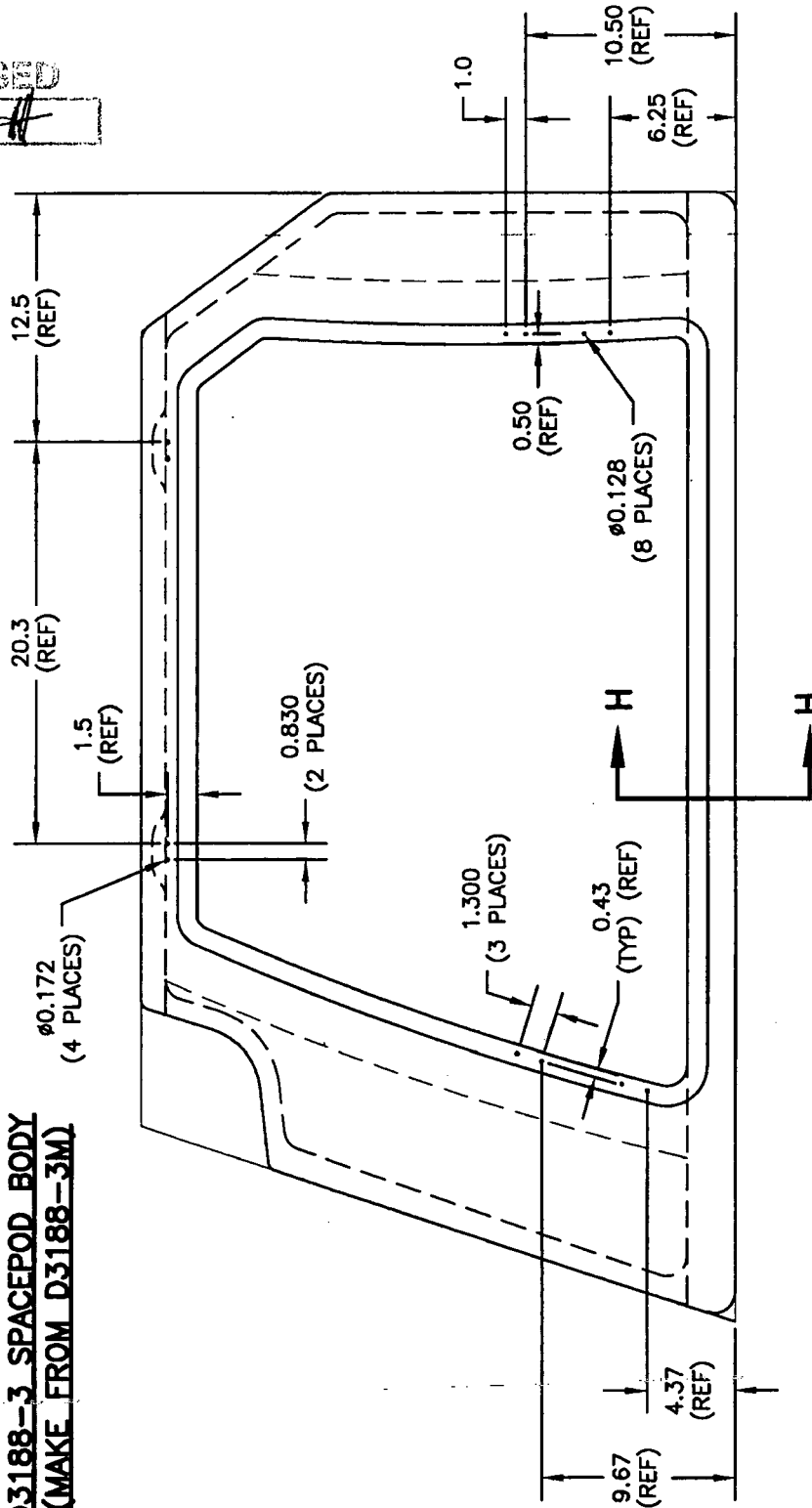
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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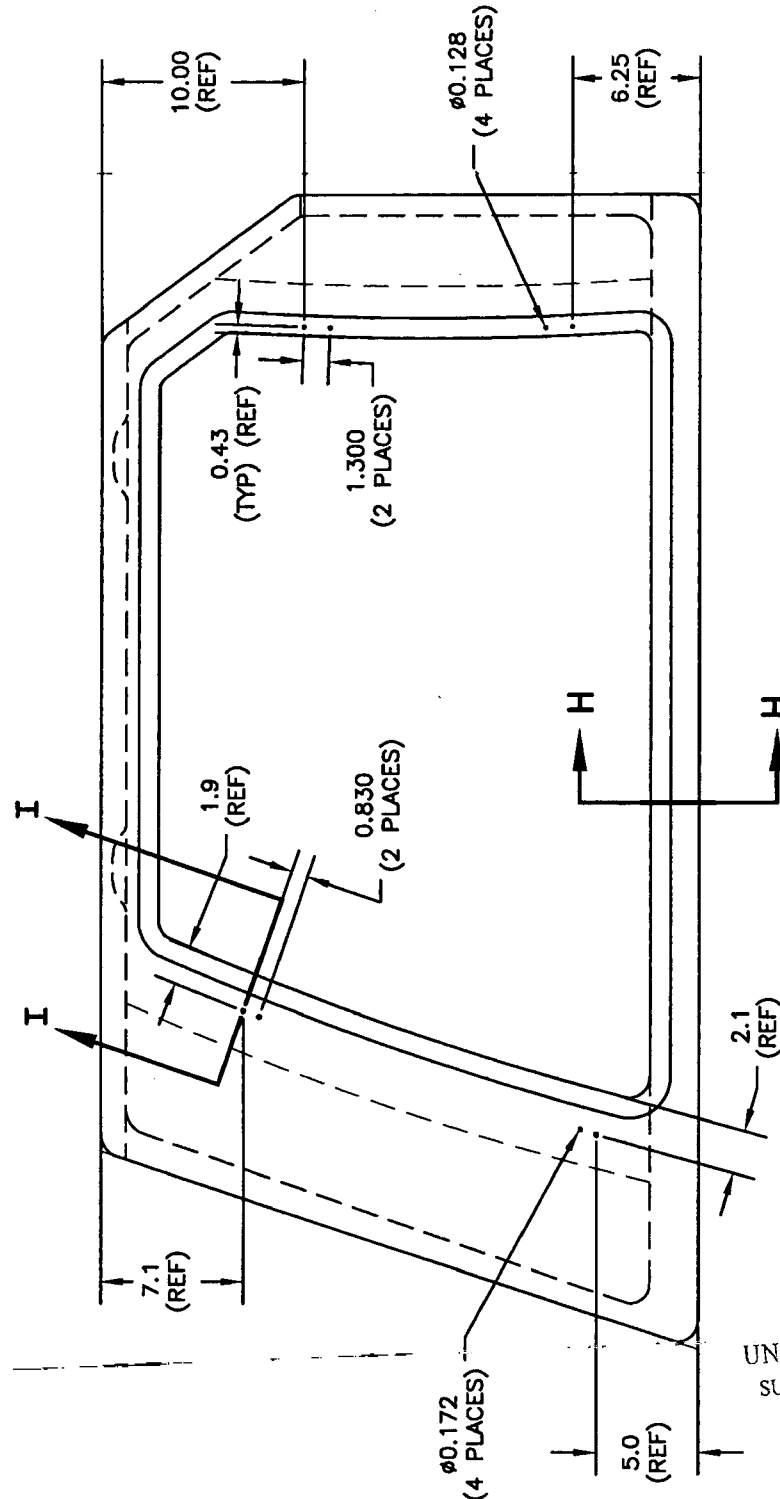
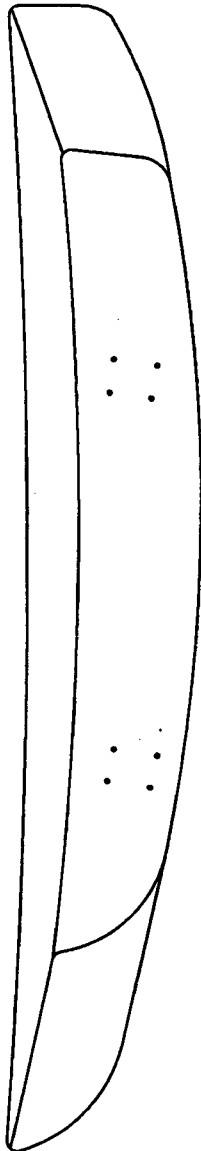
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DATE 07.04.02	TITLE SPACEPOD BODY	REV. E SHEET 8 OF 11 SCALE NTS

RELEASED

07.04.02

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

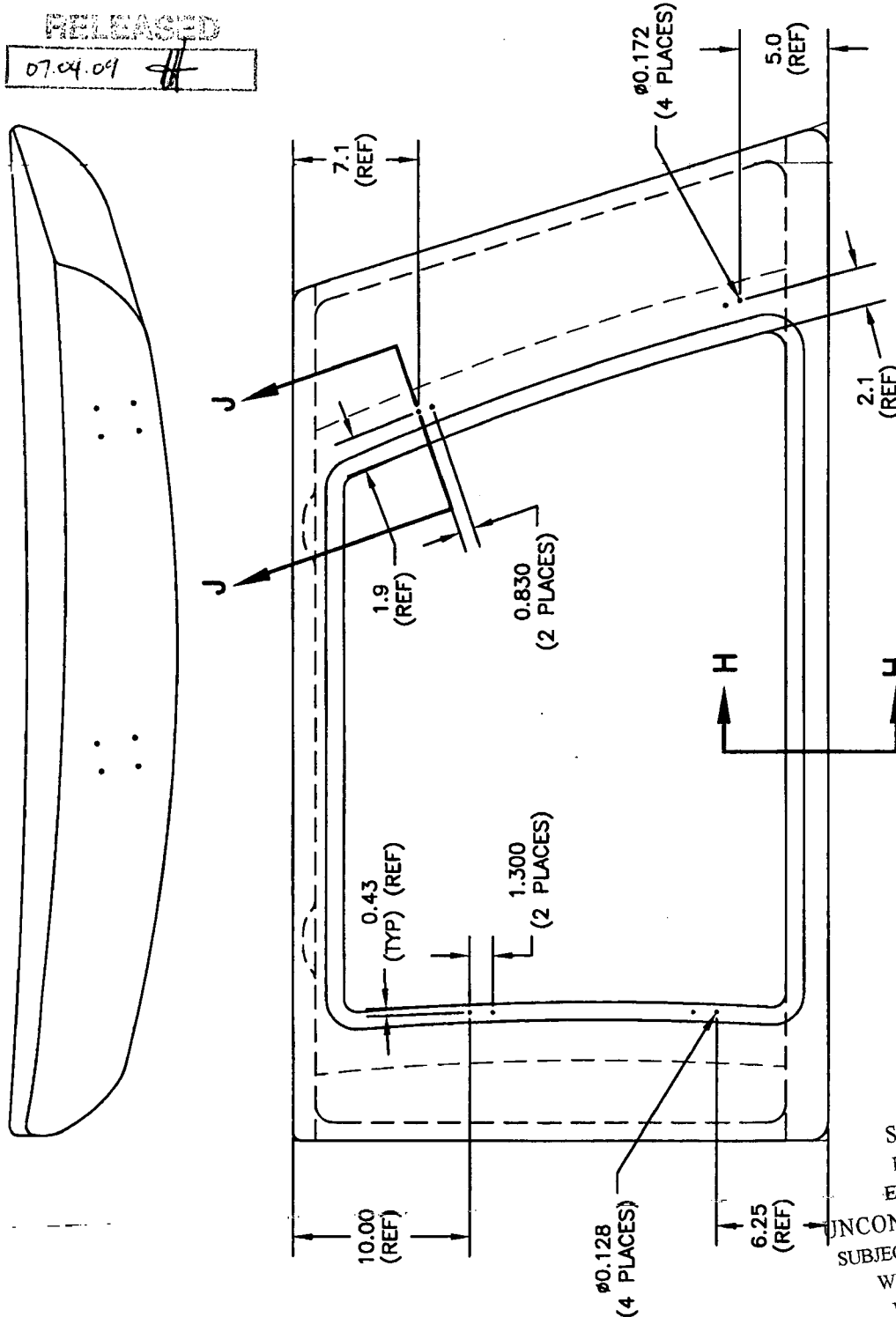
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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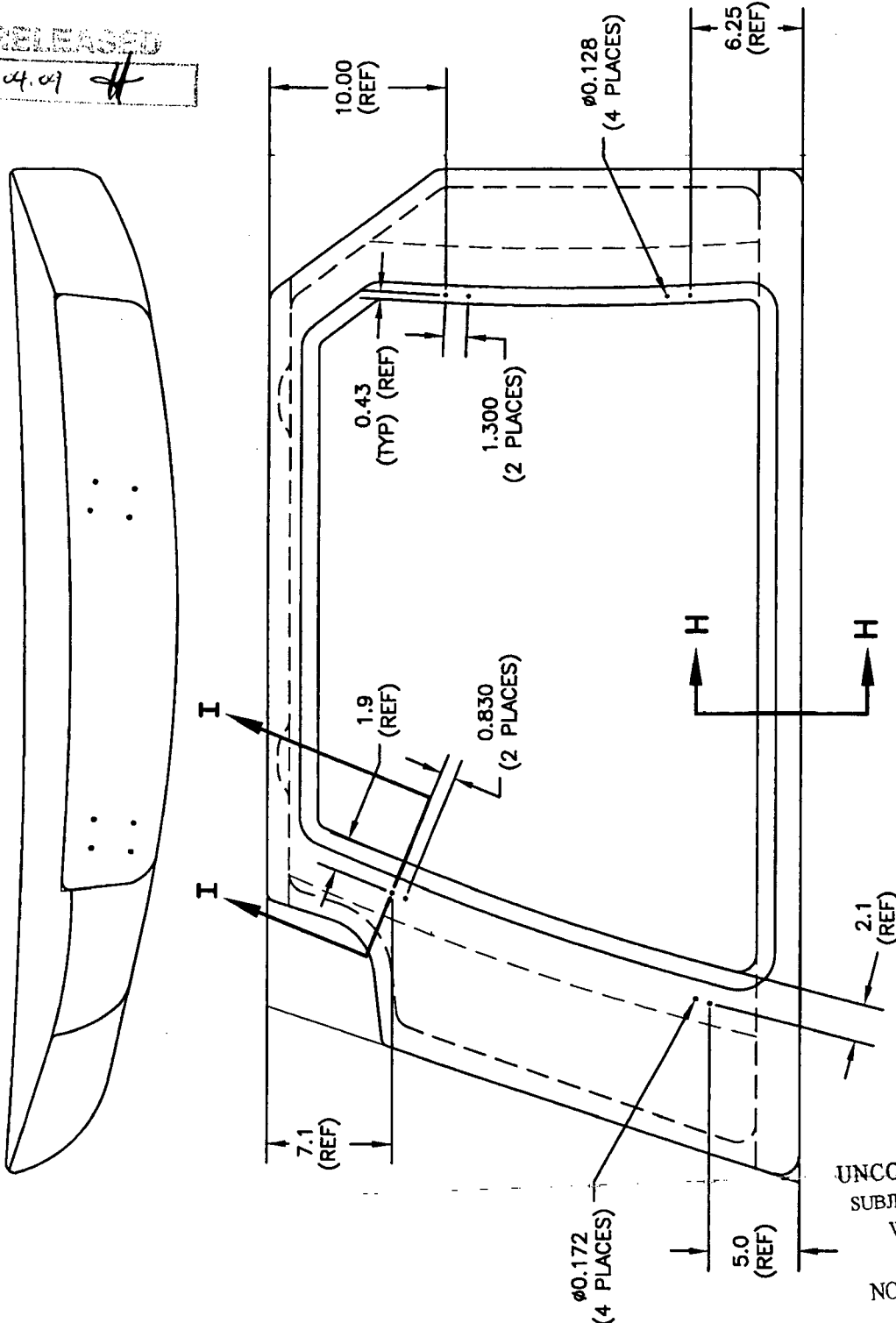
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02 **[Signature]**

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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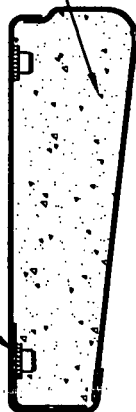
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

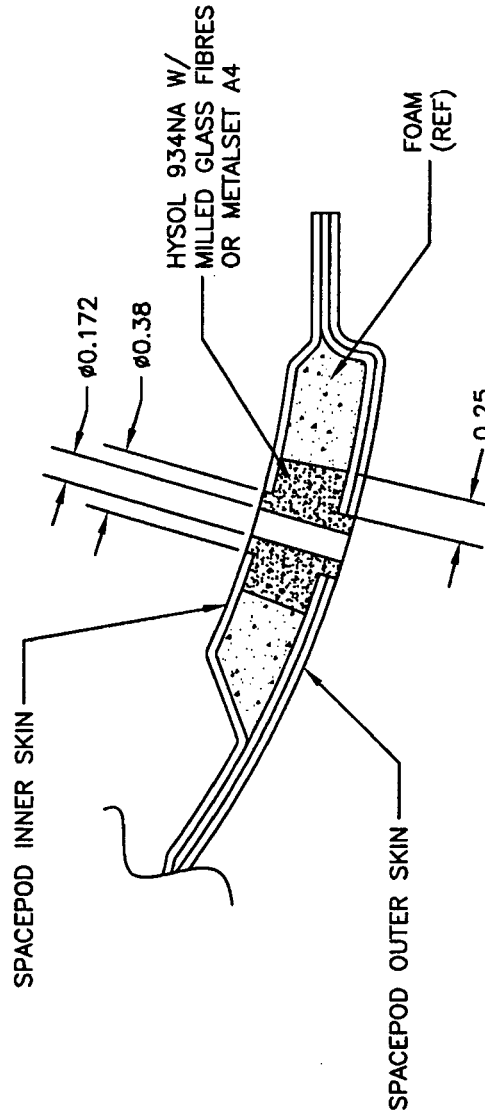
07.04.02 [Signature]

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Wednesday, 12/20/2006 1:45:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD DOOR RH
 Job Number : 30033
 Estimate Number : 12599
 P.O. Number : *N/A* Part Number : D31862M
 This Issue : 12/20/2006 S.O. No. : *N/A* Drawing Number : D3186 REV *BC* *07.01.18*
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : *BC* *07.01.18*
 Previous Run : 30032 Material : *N/A*
 Due Date : 1/20/2007 Qty: 1 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 061220
 Comment : Est Rev:A New Issue 06-12-04 ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *2767*

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

*C20612121**(1)*

2.0

D31862P

Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Spacepod Door

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

24/4/25

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

m 07/05/01

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA**m 07/05/01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 21/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 30033

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/05/08

Job Completion



12/07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

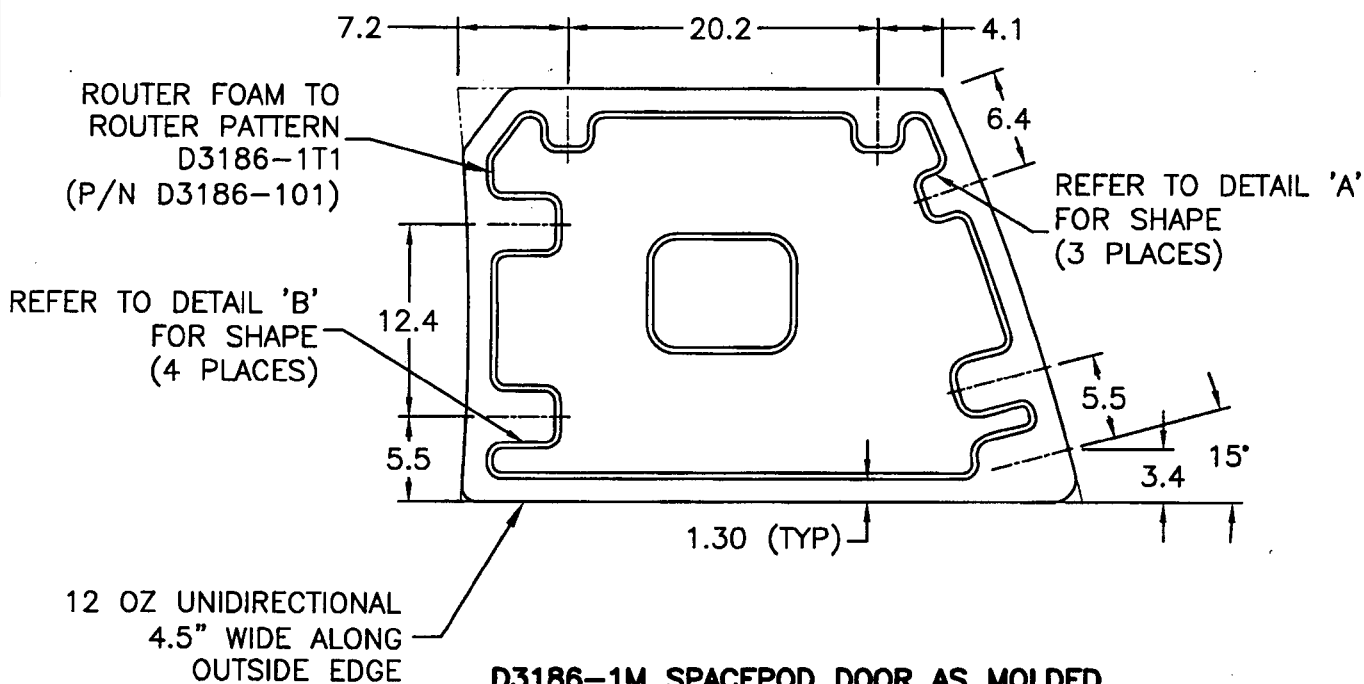
NOTE: Date & initial all entries



DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

RELEASED
06.12.22 H

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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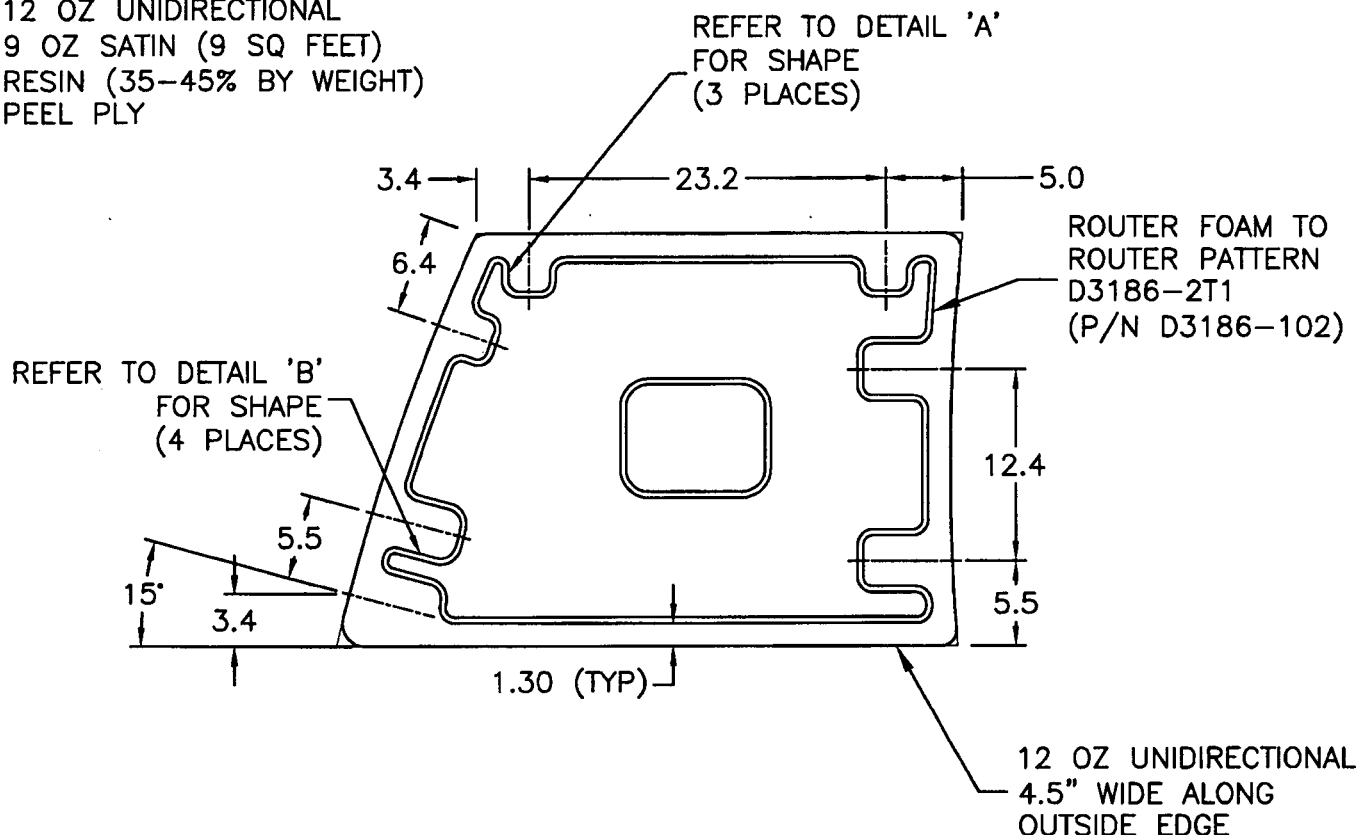
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CHECKED PH	APPROVED #	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

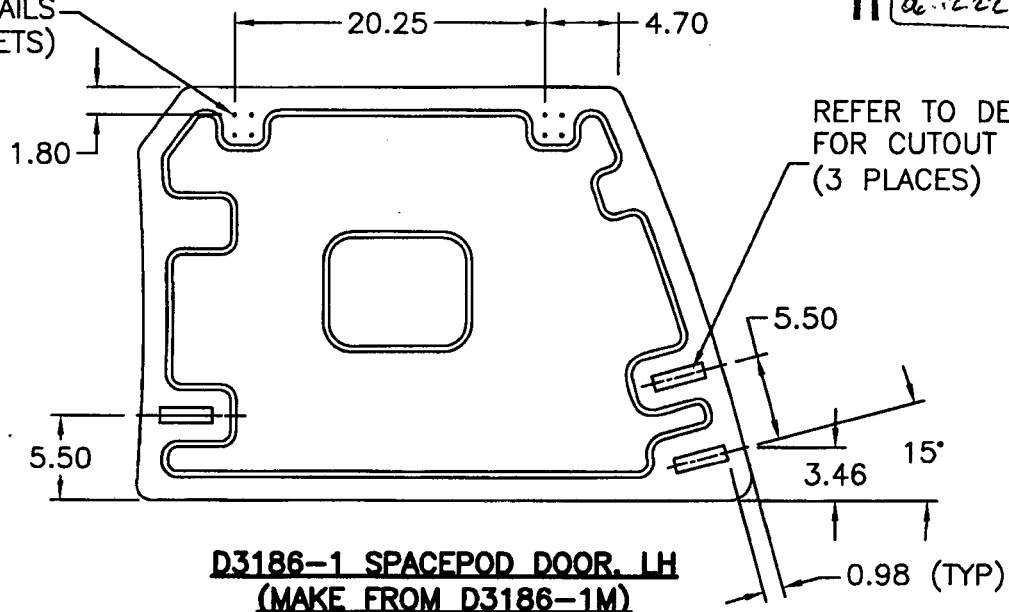
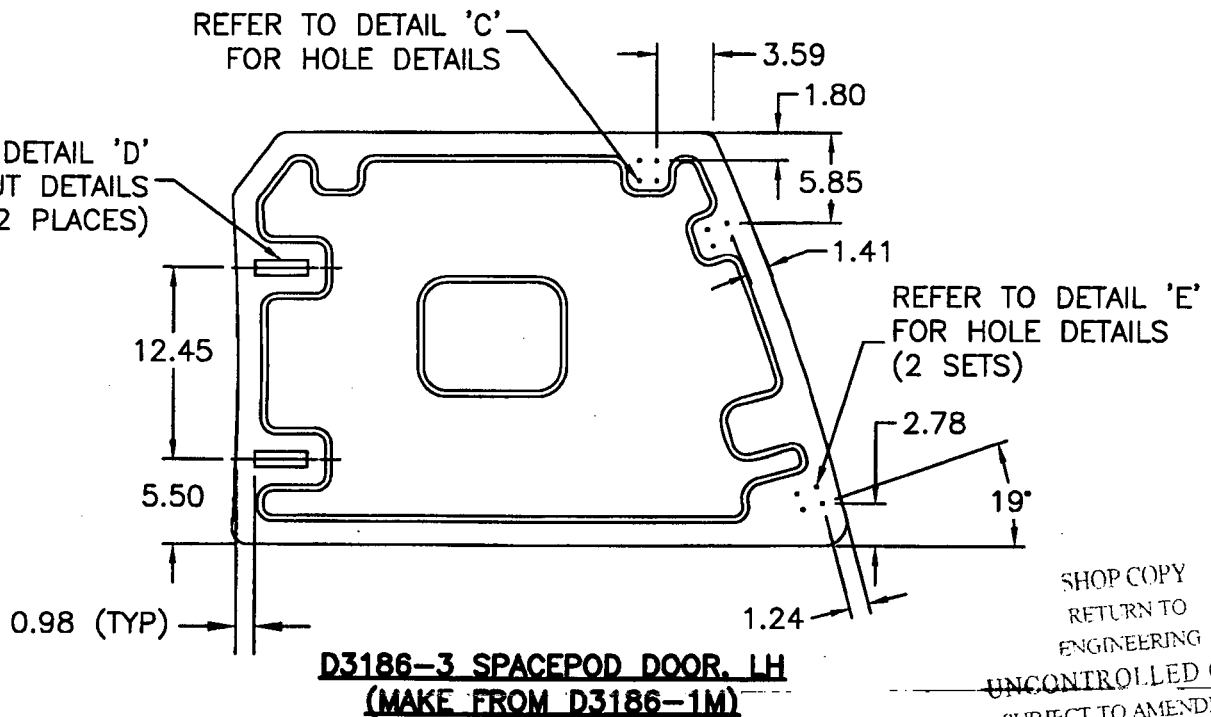
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 3 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
06-12-22 [Signature]REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)REFER TO DETAIL 'C'
FOR HOLE DETAILS
REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)**NOTES:**

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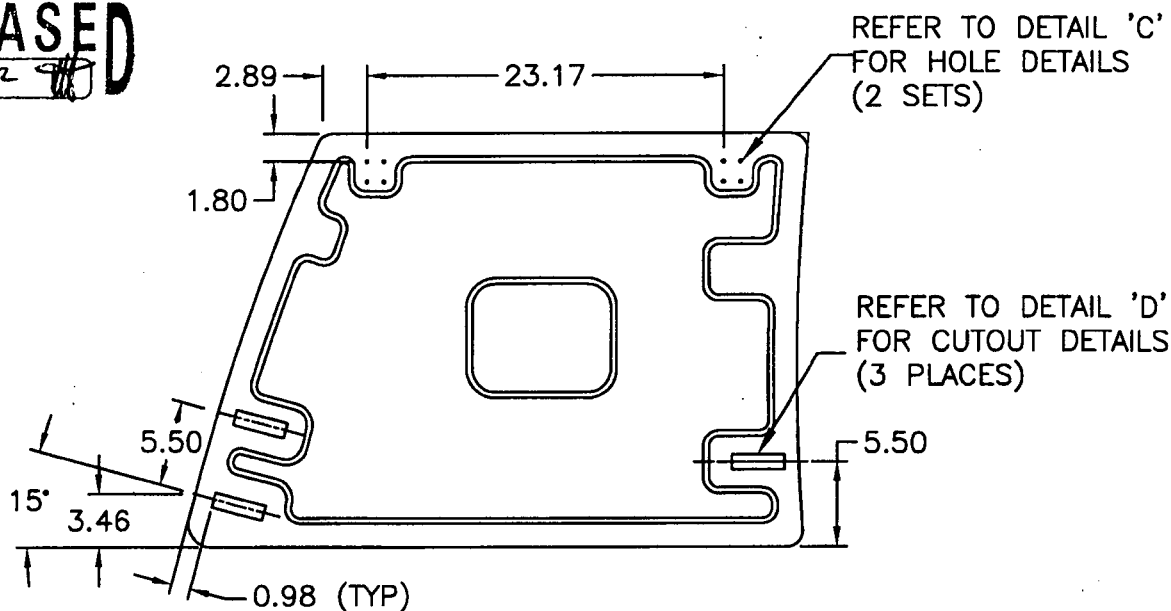
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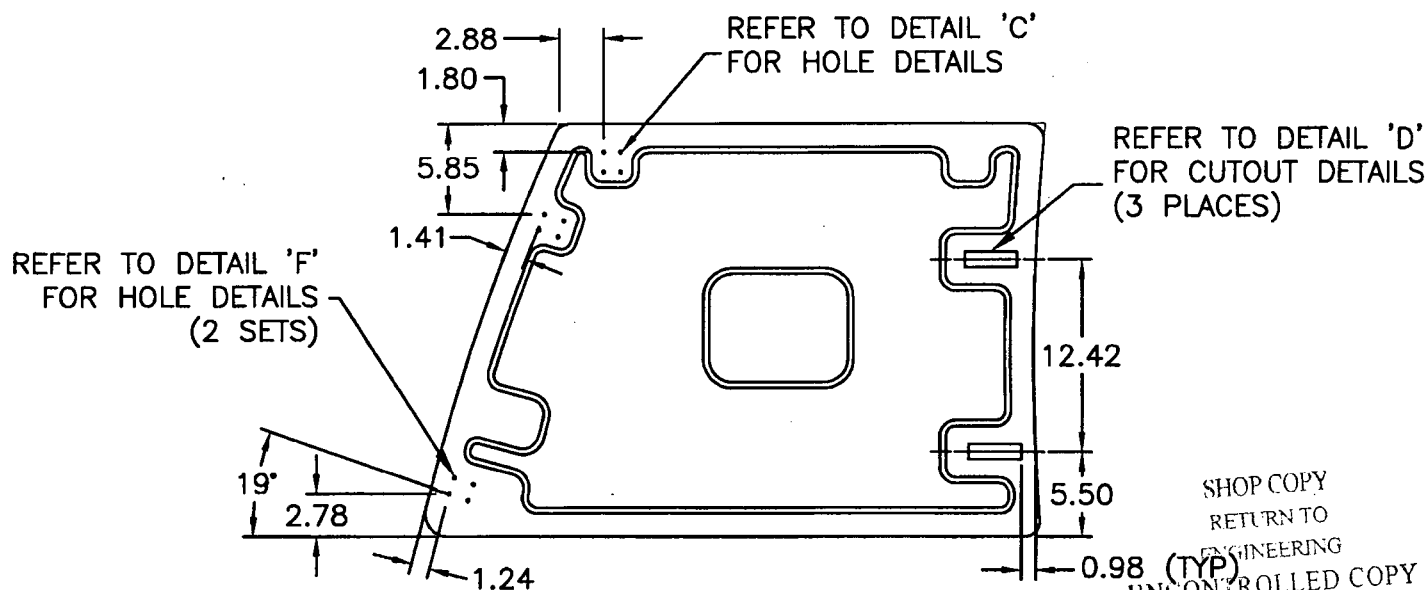


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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 4 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.22



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

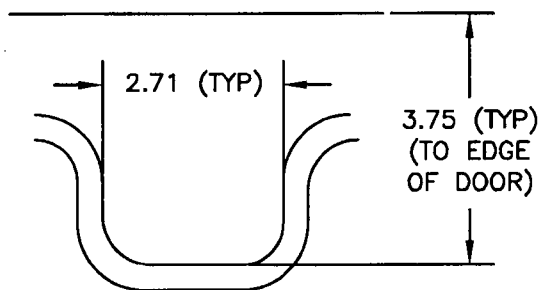
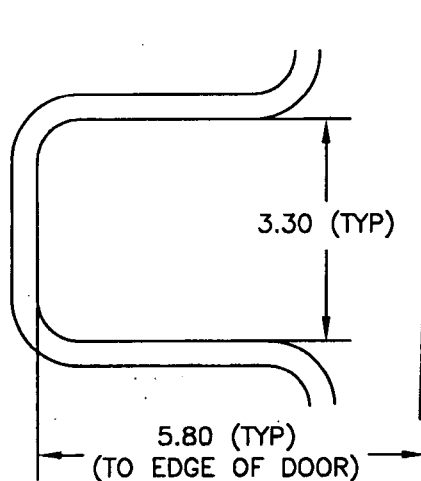
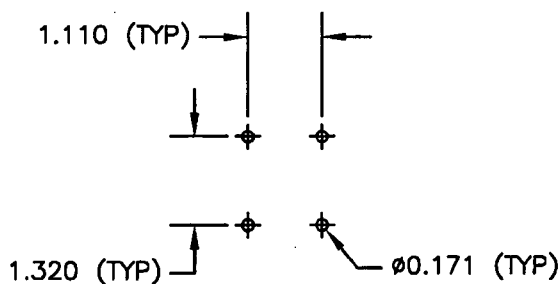
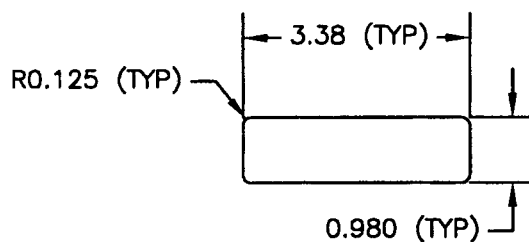
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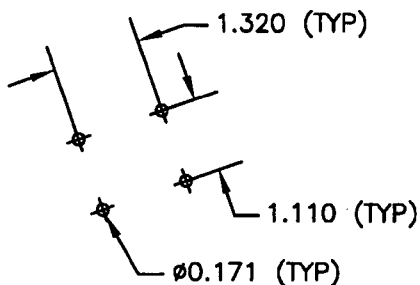
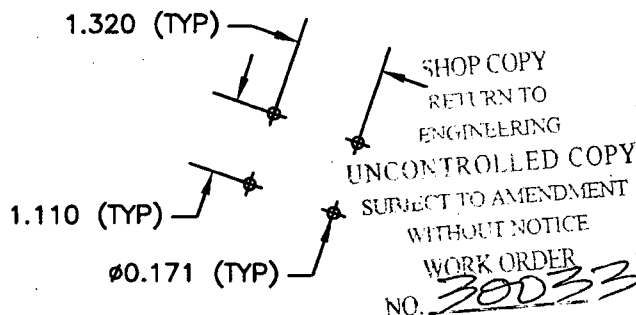
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F****NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
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RELEASED
06.12.22

Date: Monday, 4/16/2007 2:27:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 31770B	
Estimate Number : 12636	
P.O. Number : <i>N/A</i>	Part Number : D31864
This Issue : 4/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 31769B	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/10/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec	

Additional Product

w/o 30033

Job Number:



Good mlo7/05/01

Seq. #: Machine Or Operation: Description :

1.0 31770B01 SPACEPOD DOOR RH



w/o 30033



mlo7/05/01

Comment: Sub-Component SPACEPOD DOOR RH

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

mlo7/05/01

x1

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/01

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

mlo7/05/01

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/08

Job Completion



07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

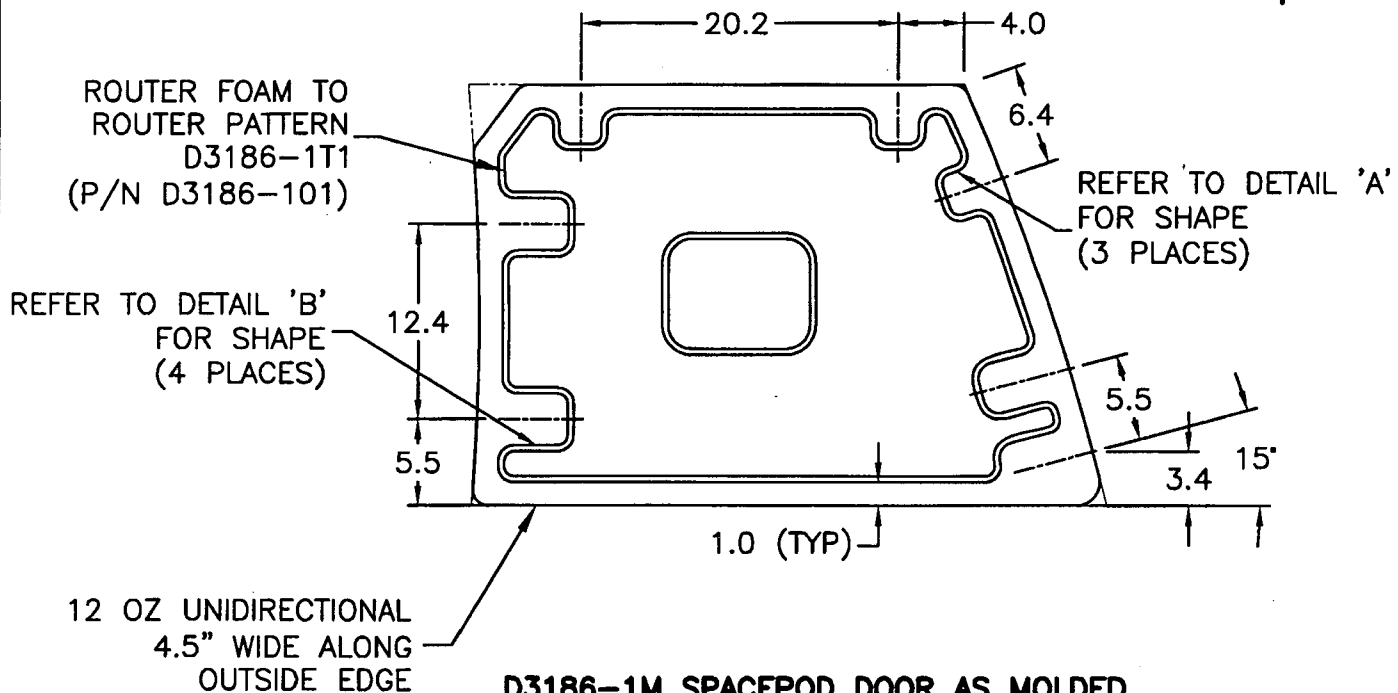
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4:0-
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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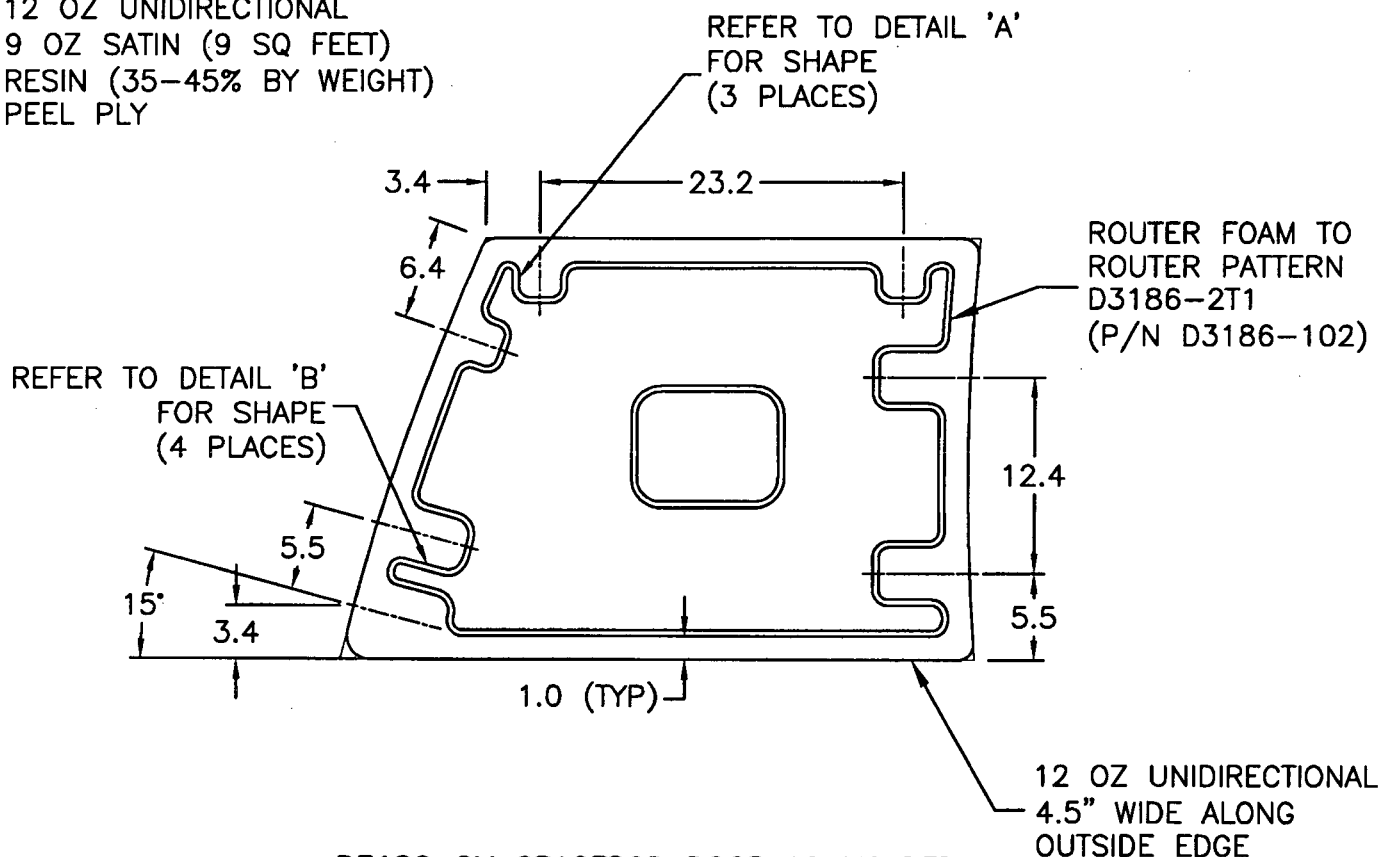
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0.
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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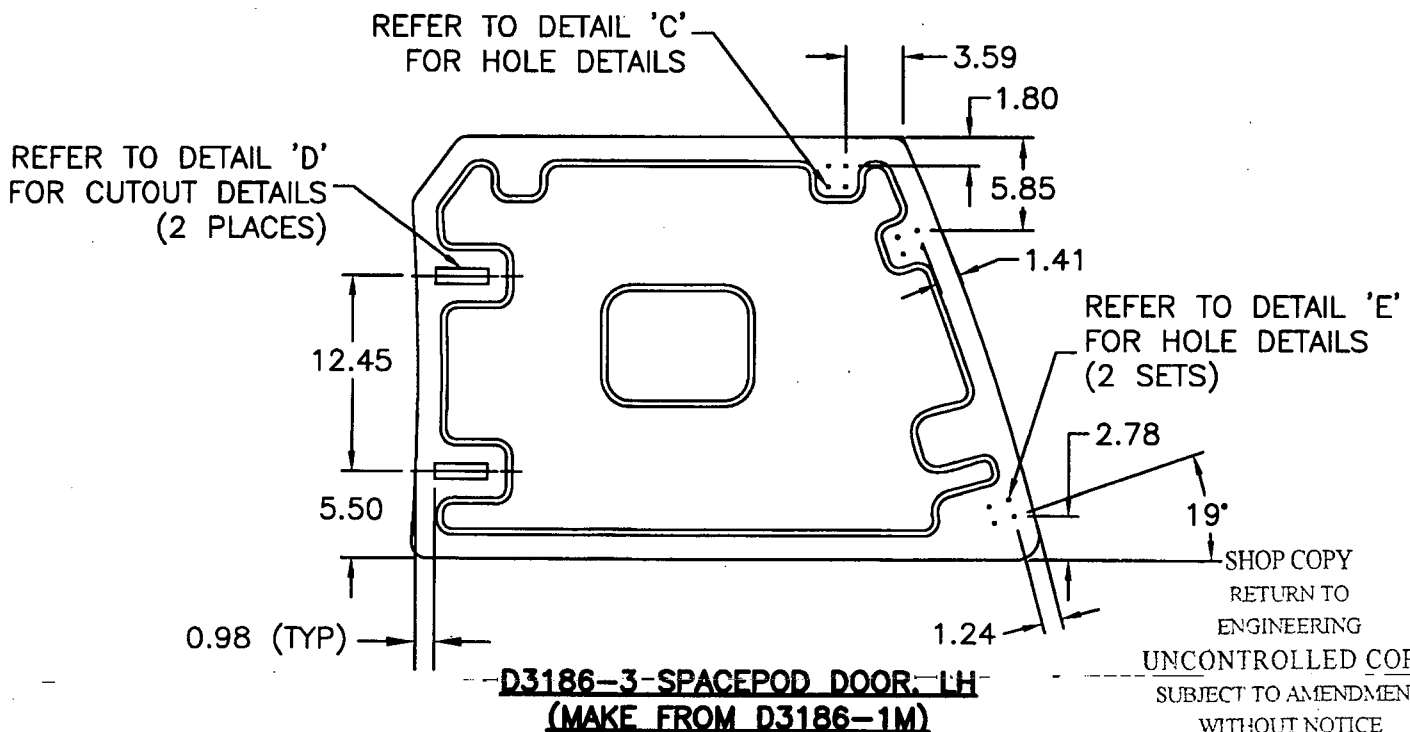
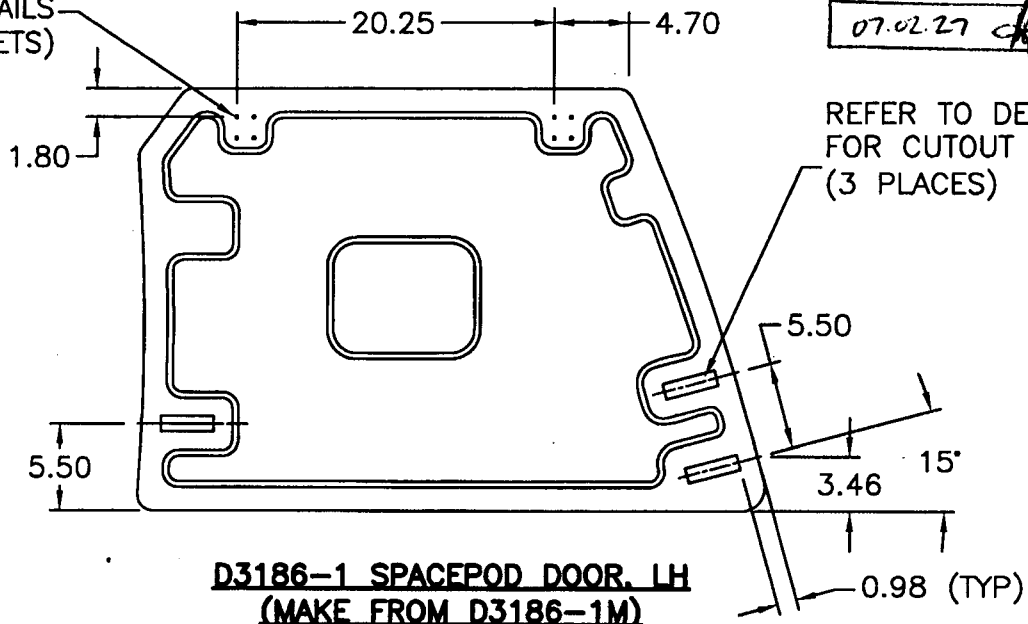
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CHECKED JB	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

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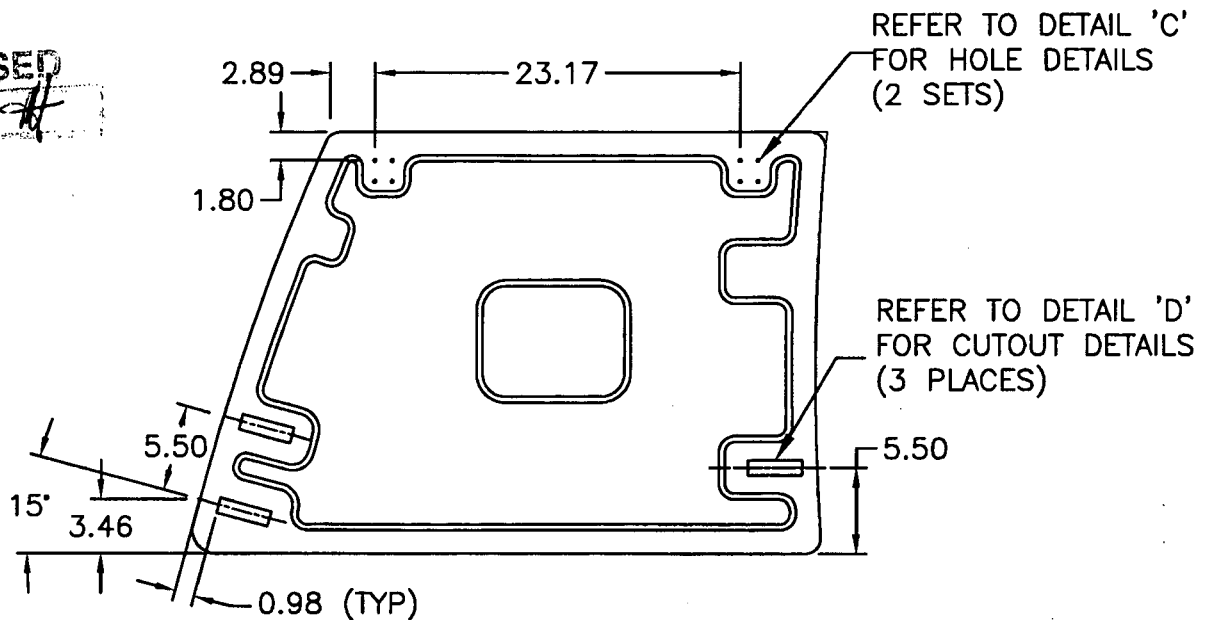
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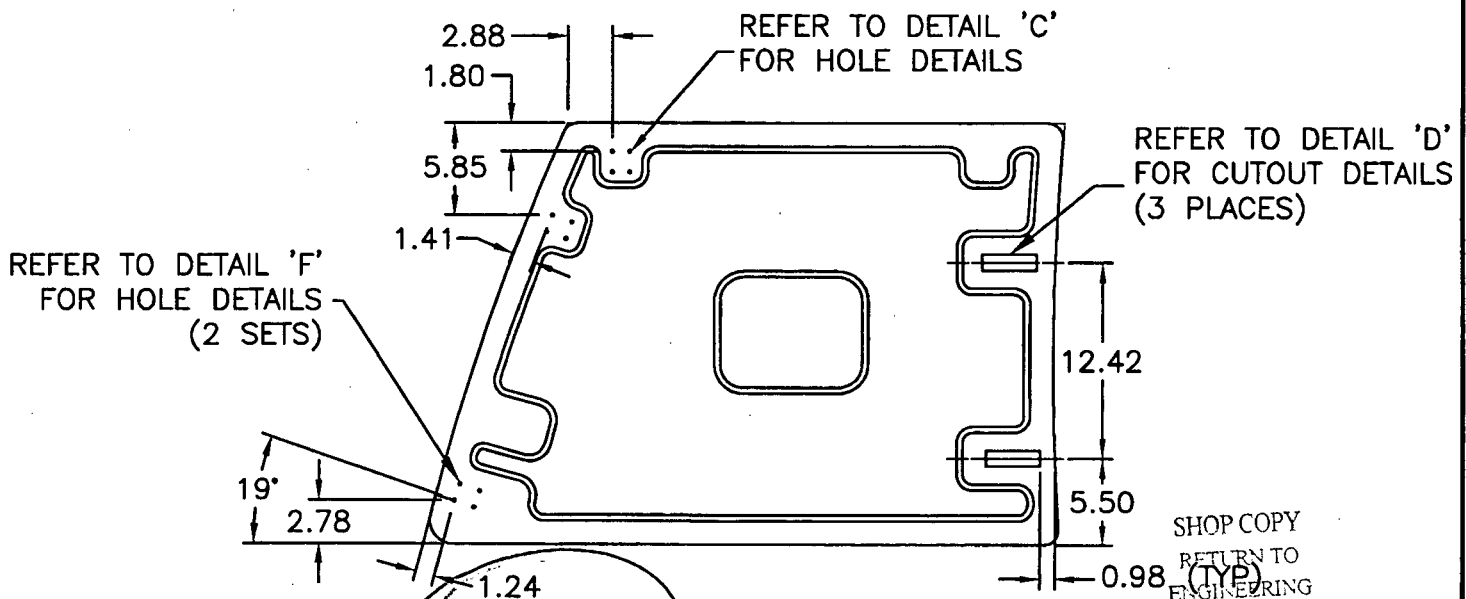
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

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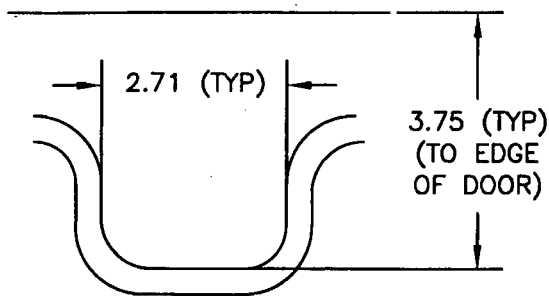
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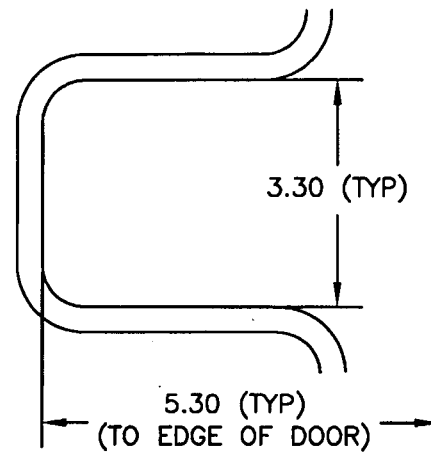
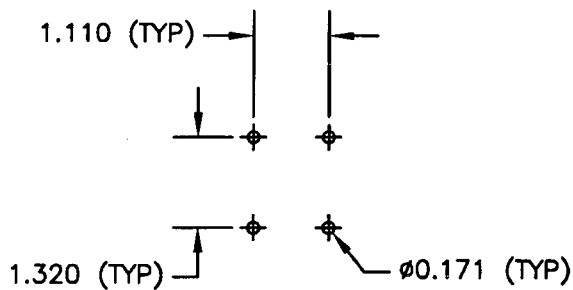
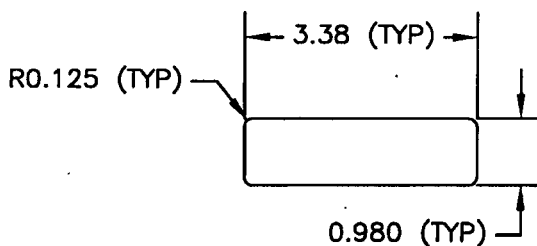
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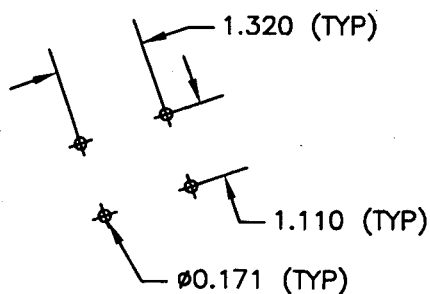
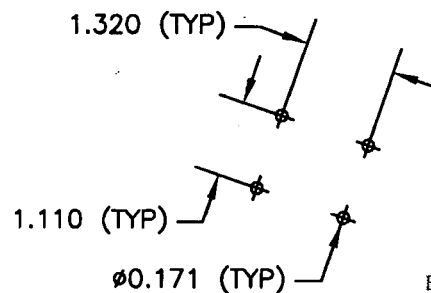
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F**

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Date: Jeudi, 2007-03-29 10:34:07
 Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD DOOR
Numéro Job :	41326	Numéro Article :	DKC134-0054
Numéro Soumission :	2586	Numéro Dessin :	D3186
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-03-29 No. B.V. :	Révision dessin :	C
Prochaine Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prochaine fois :	-- Type :	Date Dûe :	2007-04-05 Qté: 1 Udm: UNITE
Job précédente :	41250		

Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de pièce Dart Aerospace : D31862M



Process Sheet Rev.: 01 Modification générale selon les informations de l'ingénierie.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------


1.0	AC0303	Frekote 44NC
-----	--------	--------------

 Commentaire Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
 Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------


 Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: 10/04/07 Heure Début: 8:00 Heure Fin: 11:00 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

 Commentaire Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
 Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

 Commentaire Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
 Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

 Commentaire Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
 Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

 Commentaire Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
 Stretchlon 200 poche à vide Vert

Date: Jeudi, 2007-03-29 10:34:07

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41326

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish

8.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5453

9.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentaire Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 5/04/07 Heure Début: 8:00 Heure Fin: 8:45 Sceau:

11.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-6086-1

13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 11/04/07 Heure Début: 12:30 Heure Fin: 12:45 Sceau:

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Numéro Job: 41326	Nom Dessin: SPACEPOD DOOR Numéro Article: DKC134-0054
---	--

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
14.0	LAMINAGE.	LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date 11/04/07 Heure Début: 12:45 Heure Fin: 1:00 Sceau:



15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date 11/04/07 Heure Début: 1:00 Heure Fin: 1:15 Sceau:



Curing Début: 1:15 Curing Fin: _____

16.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6086-1

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41326

Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: 10/04/07 Heure Début: 12:30 Heure Fin: 12:45 Sceau:



19.0

AAC0452

Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)
Polybond B46F N° de Lot: 5979

20.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D3186-102 (Porte D3186-2) 1-5826-1

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÉCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 12/04/07 Heure Début: 9:30 Heure Fin: 9:50 Sceau:



22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Date: Jeudi, 2007-03-29 10:34:07

Alisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41326

Numéro Article: DKC134-0054

Numéro Job:



Séq.:



Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond

Date: 12/04/07 Heure Début: 9:50 Heure Fin: 10:00 Sceau:  

Curing Début: 9:30 Curing Fin: 10:50

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total: 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6086-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 13/04/07 Heure Début: 11:10 Heure Fin: 11:15 Sceau: 

26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 13/04/07 Heure Début: 11:15 Heure Fin: 11:45 Sceau:   

Date: Jeudi, 2007-03-29 10:34:07
Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 41326

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 13/04/07 Heure Début: 11:45 Heure Fin: 12:00 Sceau:



Curing Début: 12:00 Curing Fin: _____

28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
------	-------------	----------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 16/04/07 Heure Début: 10h15 Heure Fin: 10h20 Sceau:



29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
------	-----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: 16/04/07 Heure Début: 10h20 Heure Fin: 11h00 Sceau:



30.0	AAC0671	Dupont Primer N° 1104S
------	---------	------------------------

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)
Dupont Primer N° 1104S

N° de Lot: 1-5931-2

Date: Jeudi, 2007-03-29 10:34:07

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41326

Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTÉ(s)/Unit Total : 0.2800 PINTÉ(s)
Dupont Activator N° 7975S

N° de Lot: 1-6041-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: 1-5390-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

APR 17 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DARTAppliquer une première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.
Application primer

Laisser sécher pendant 3 heures.

APR 17 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____



35.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

Date: Jeudi, 2007-03-29 10:34:07

l'isateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41326Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 SikkensN° de Lot: 1-6005-1

37.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

38.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: 18-4-07 Heure Début: 12:15 Heure Fin: 12:00 Sceau:

39.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6005-2

40.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTÉ(s)/Unit Total : 0.2800 PINTÉ(s)
Dupont Activator N° 7975S N° de Lot: 1-6005-1

41.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-6005-2

42.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

APR 18 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 20.0000Min. Total Run : 0.3333Hrs
APPLICATION DE PRIMERAppliquer une deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.
Application de primer.Date: APR 18 2007 Heure Début: _____ Heure Fin: _____ Sceau:

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41326

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.:

Machine ou Opération:

Description :

44.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
INSPECTION PIÈCE DART 19-4-07



Emballage QT 1

19/4/07





DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11860
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
20/04/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30013 Dwg. Rév.: C Job: 41317 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30023 Dwg. Rév.: C Job: 41111 U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30033 Dwg. Rév.: C Job: 41326 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30043 Dwg. Rév.: C Job: 40887 U de M : Each			
				mul 07/05/01			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357

ml07/05/01

Date:
User:Wednesday, 12/20/2006 1:46:15 PM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY RH
Job Number :	30043		
Estimate Number :	12596		
P.O. Number :	N/A	Part Number :	D31882M
This Issue :	12/20/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3188 REV C LE 07.01.18
First Issue :	N/A	Project Number :	N/A
Previous Run :	30042	Drawing Revision :	BC LE 07.01.18
	Type :	Material :	N/A
	PURCHASED PARTS	Due Date :	1/20/2007
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JF 061220		
Comment :	Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8 D2213 Spacer Batch: B30049 C207101102 (8)

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: 2767
Description: D3188-2M BODY
SHIP: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

C20612121 (1)

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

PC 7/14/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PS Date: 09/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:46:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 30043

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 07/05/01

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EA*

ml 07/05/01

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
07/05/08

Job Completion



07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	REV. C
DATE 06.12.13	TITLE SPACEPOD BODY	SHEET 1 OF 11
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

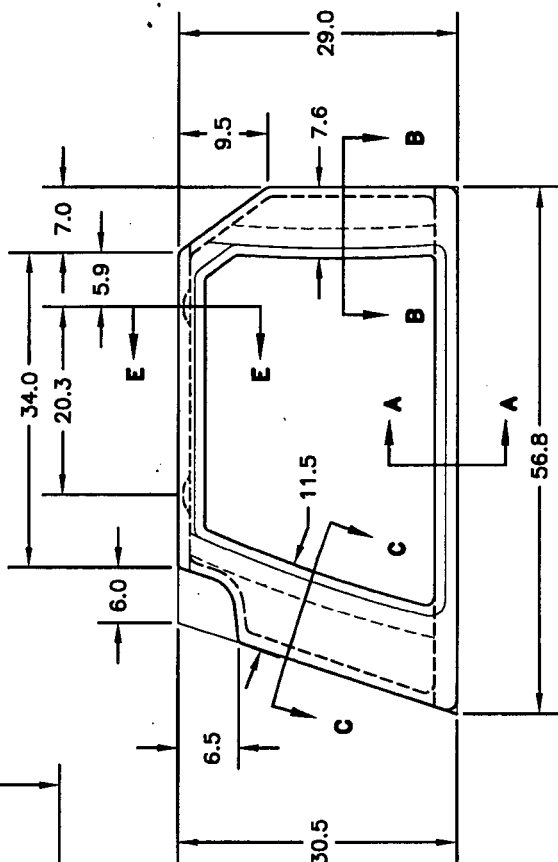
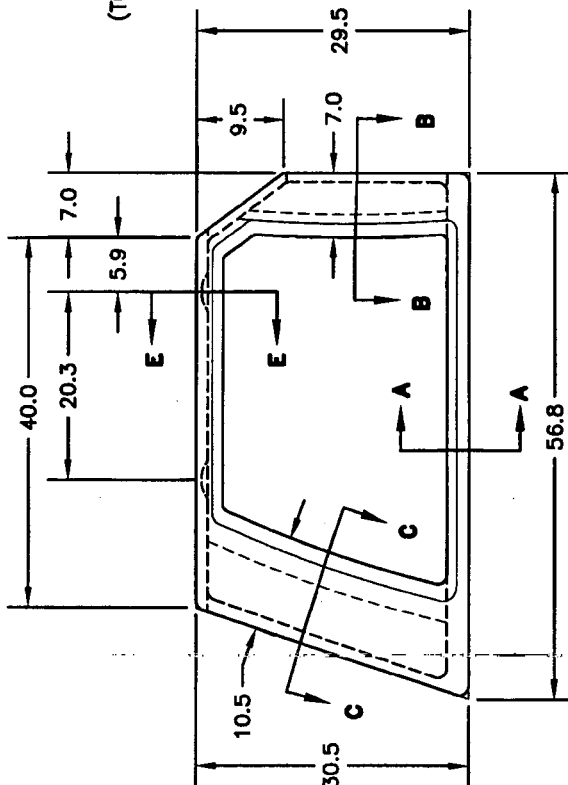
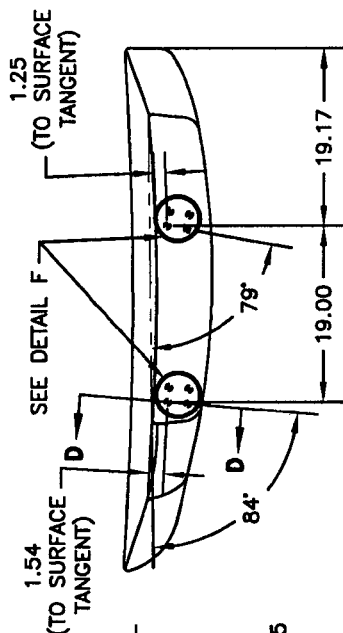
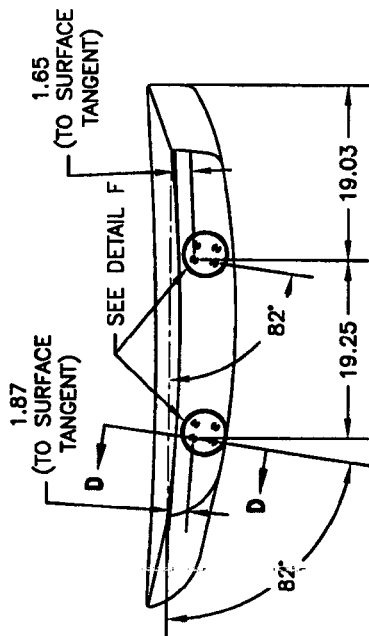
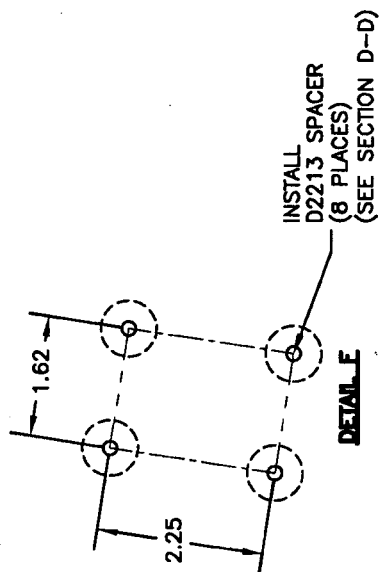
5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 30043

RELEASED
06.12.22



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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 2 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY

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06-12-2013

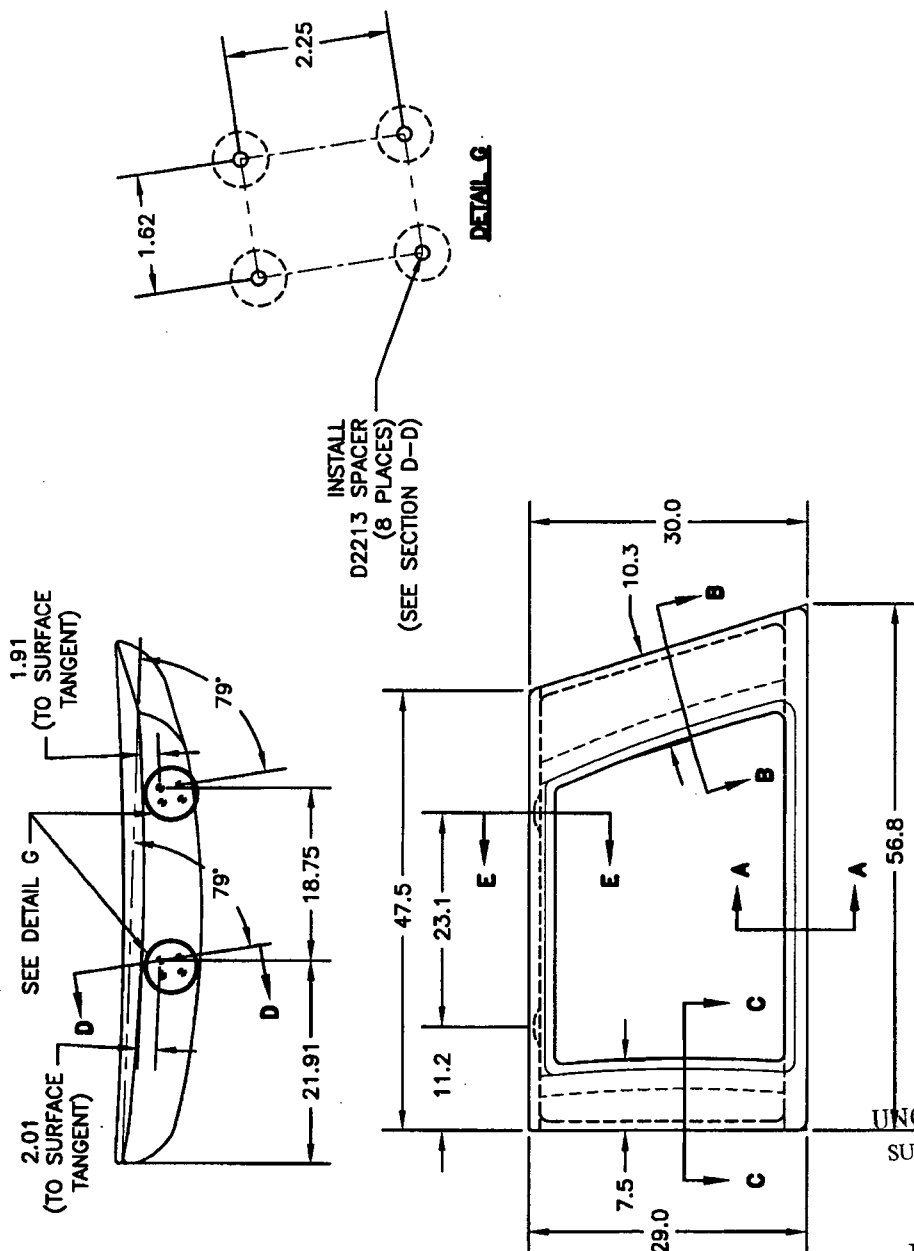
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 3 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-2M SPACEPOD BODY

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06.12.22

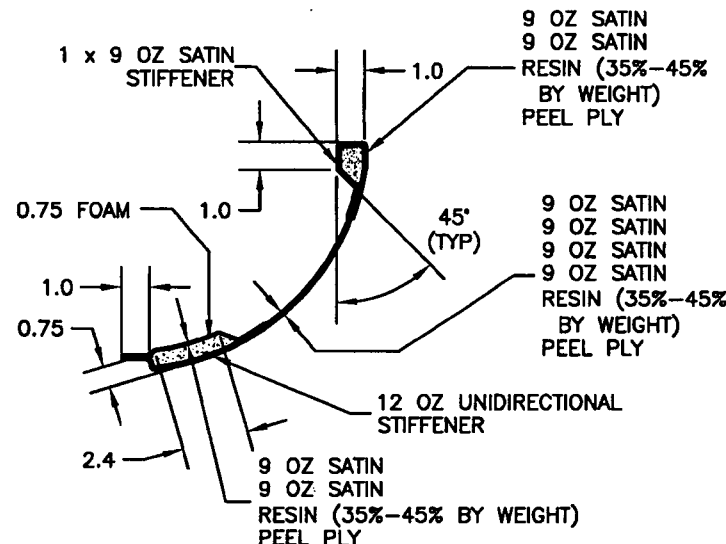
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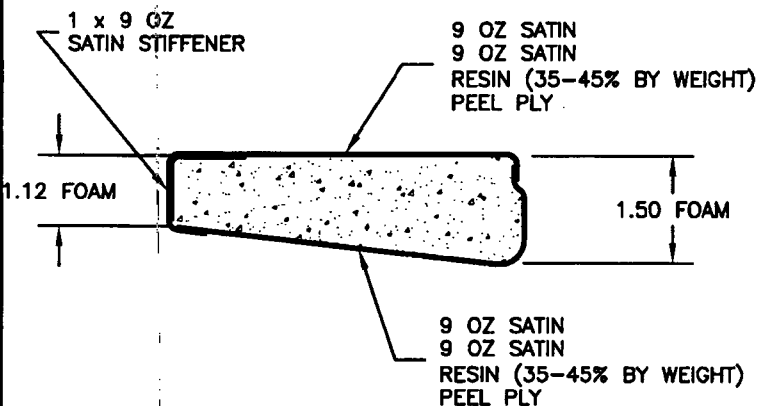
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DART

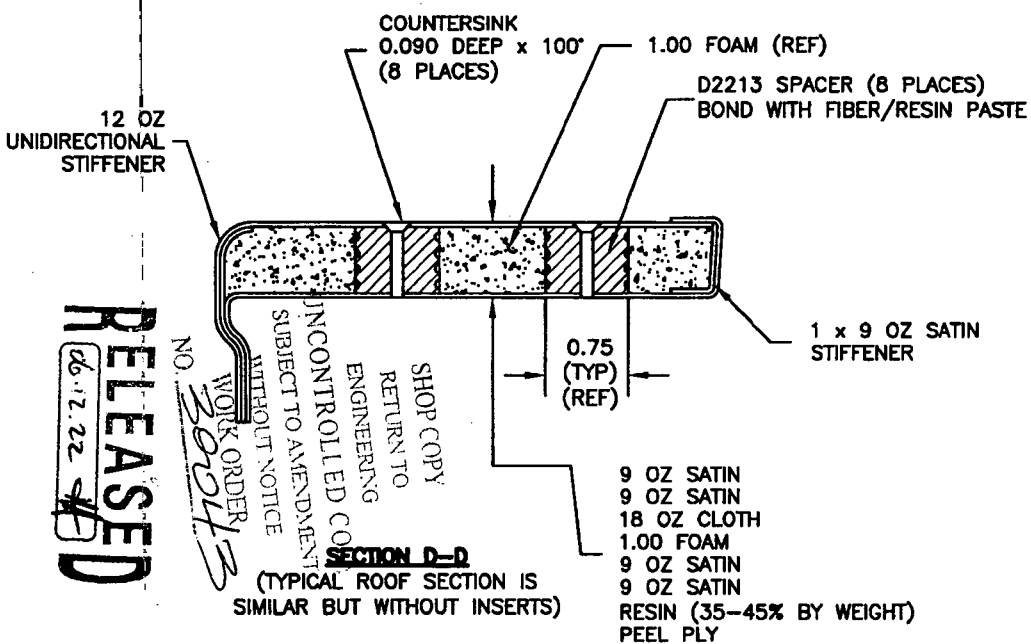
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA	
DATE	06.12.13	DRAWING NO.	D3188		SHEET 4 OF 11
		TITLE	SPACEPOD BODY		SCALE
					NTS



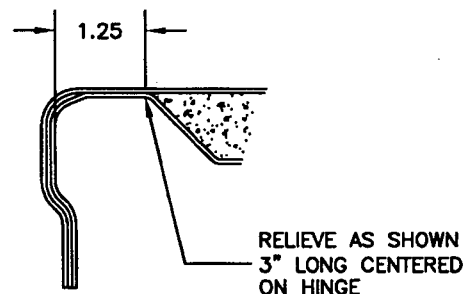
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

RELEASED
06.12.22

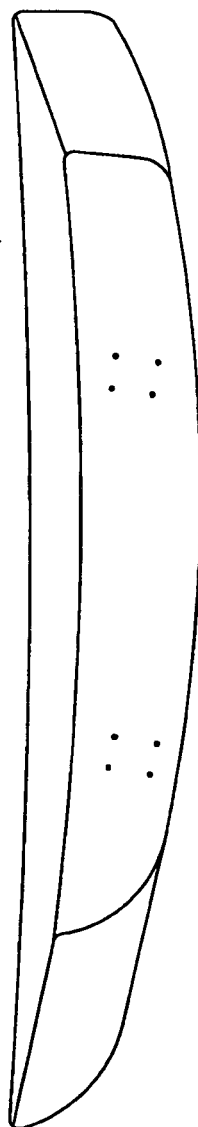
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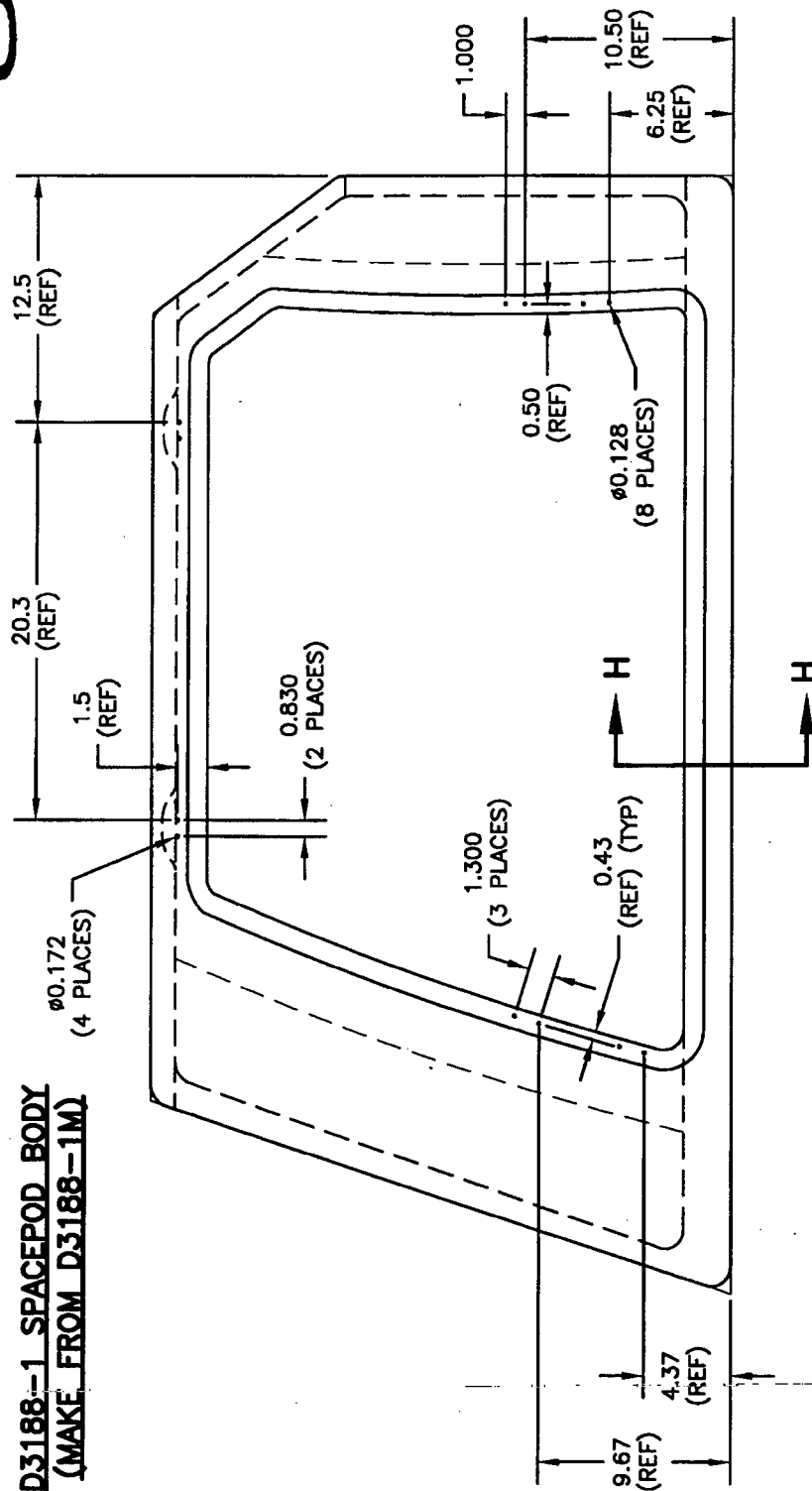


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CHECKED PH	APPROVED H	DRAWING NO. D3188	REV. C SHEET 5 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22



**D3188--1 SPACEPOD BODY
(MAKE FROM D3188--1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186--1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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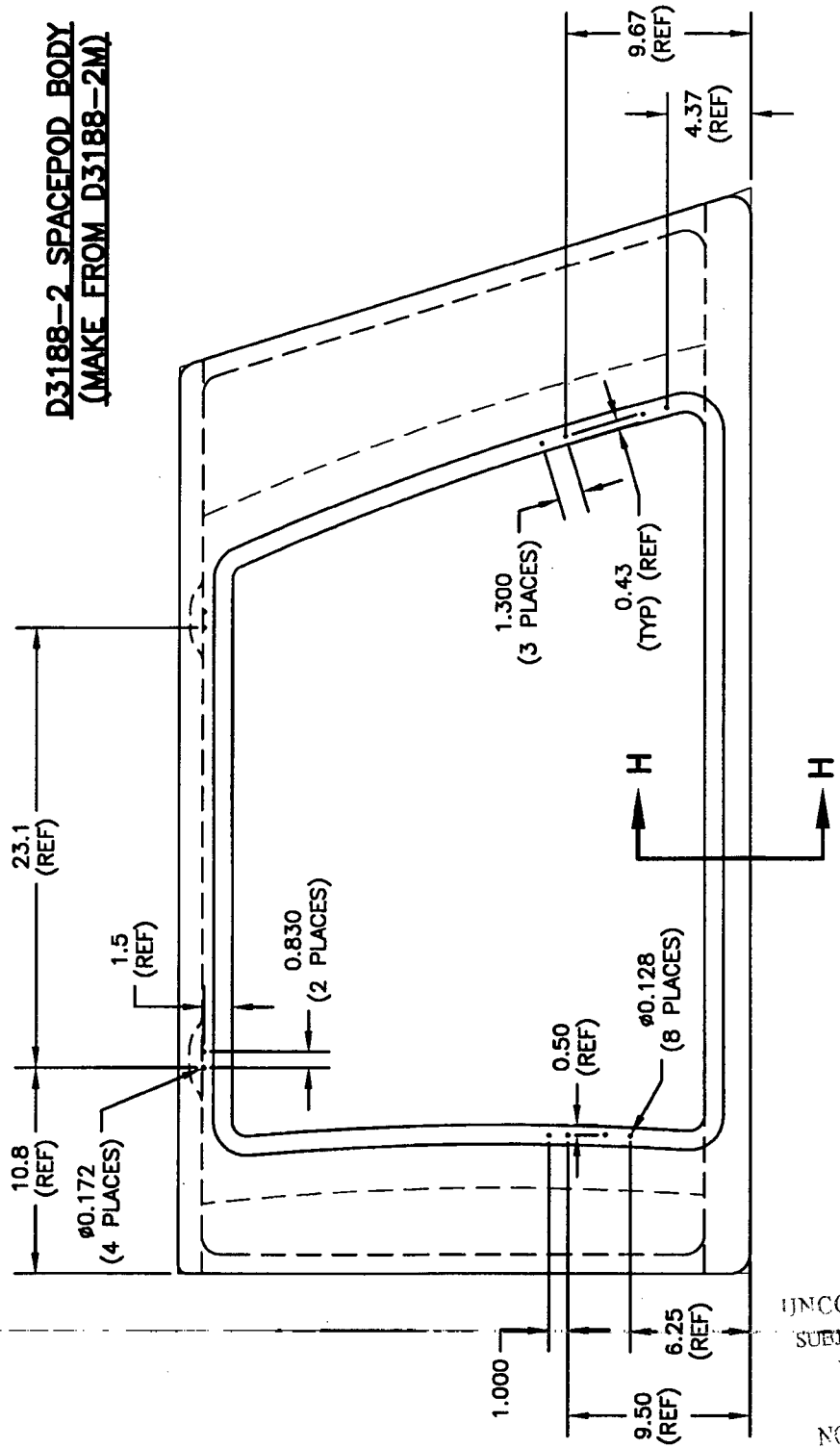
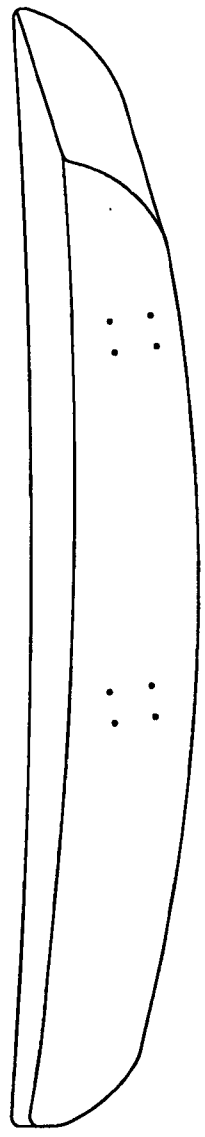
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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

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06.12.22 [Signature]

D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:
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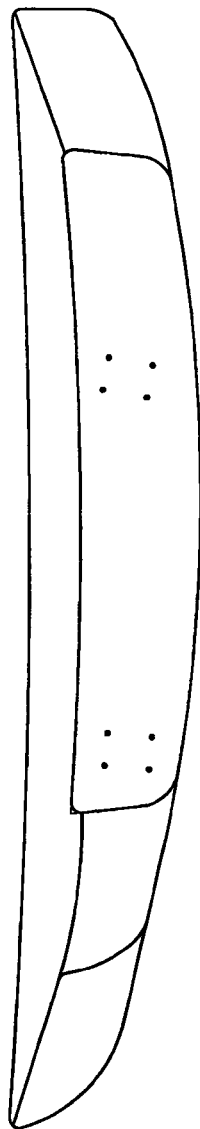
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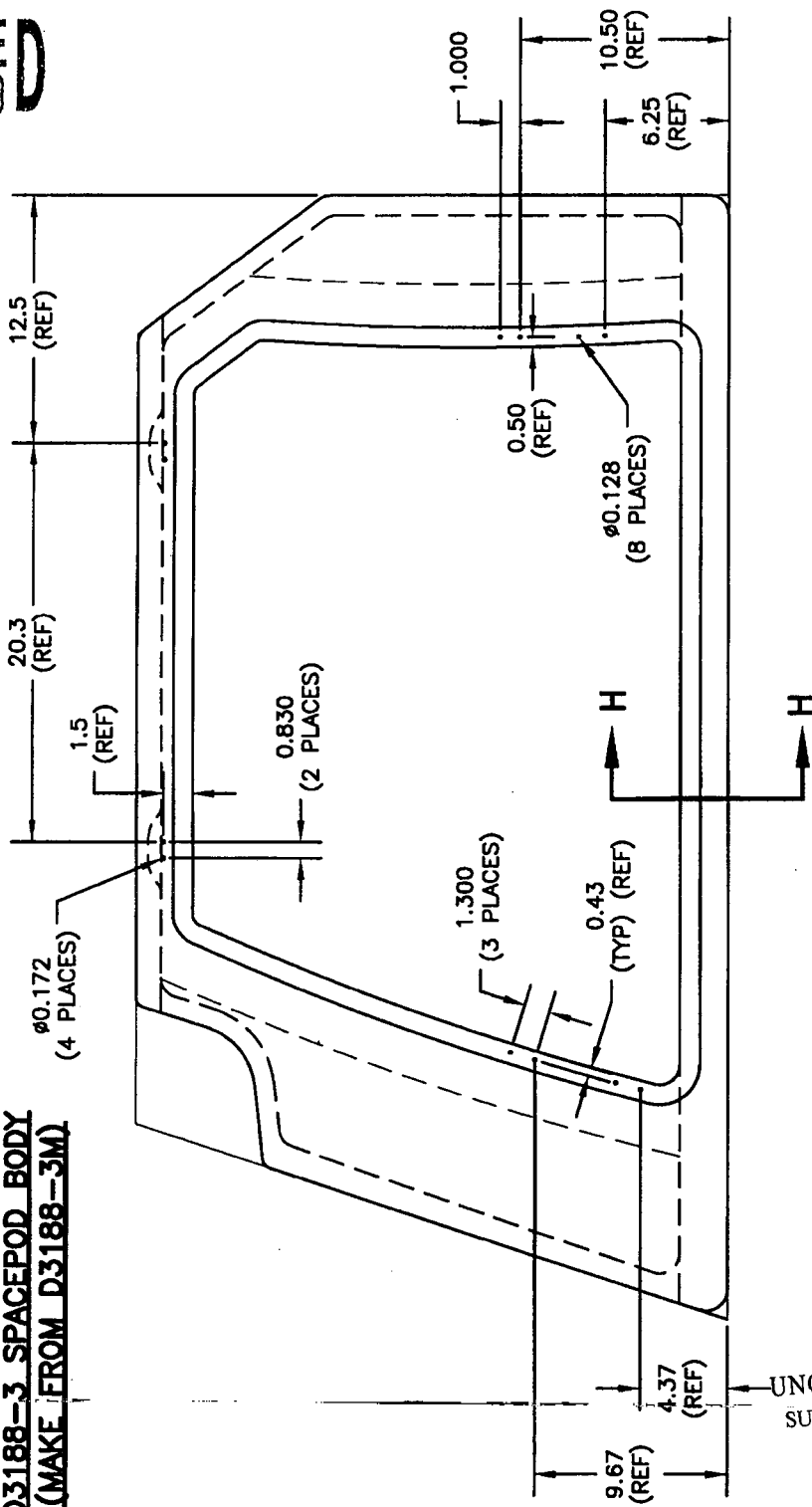


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
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**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
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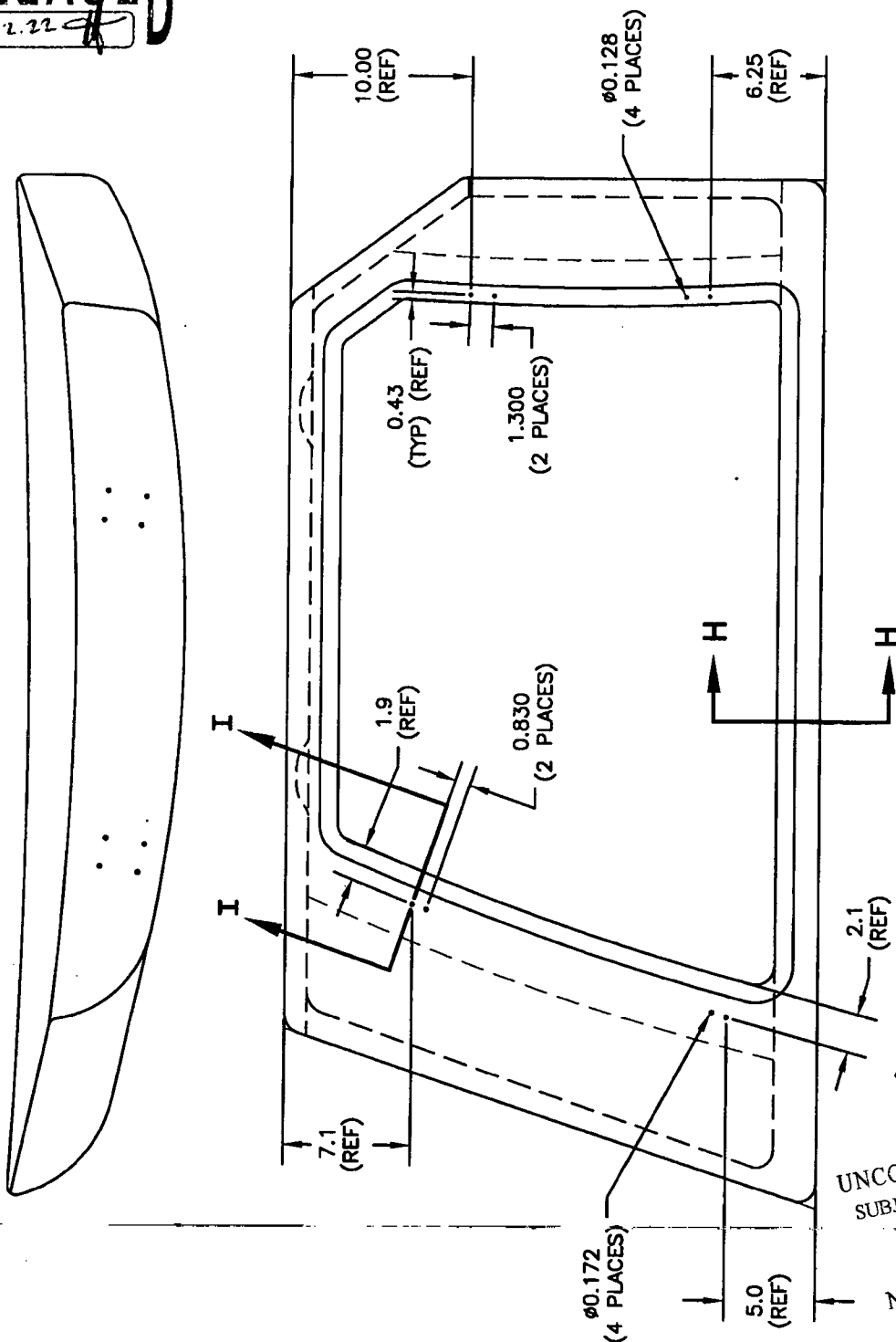
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DATE 06.12.13	TITLE SPACEPOD BODY	REV. C SHEET B OF 11 SCALE NTS

RELEASED
06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
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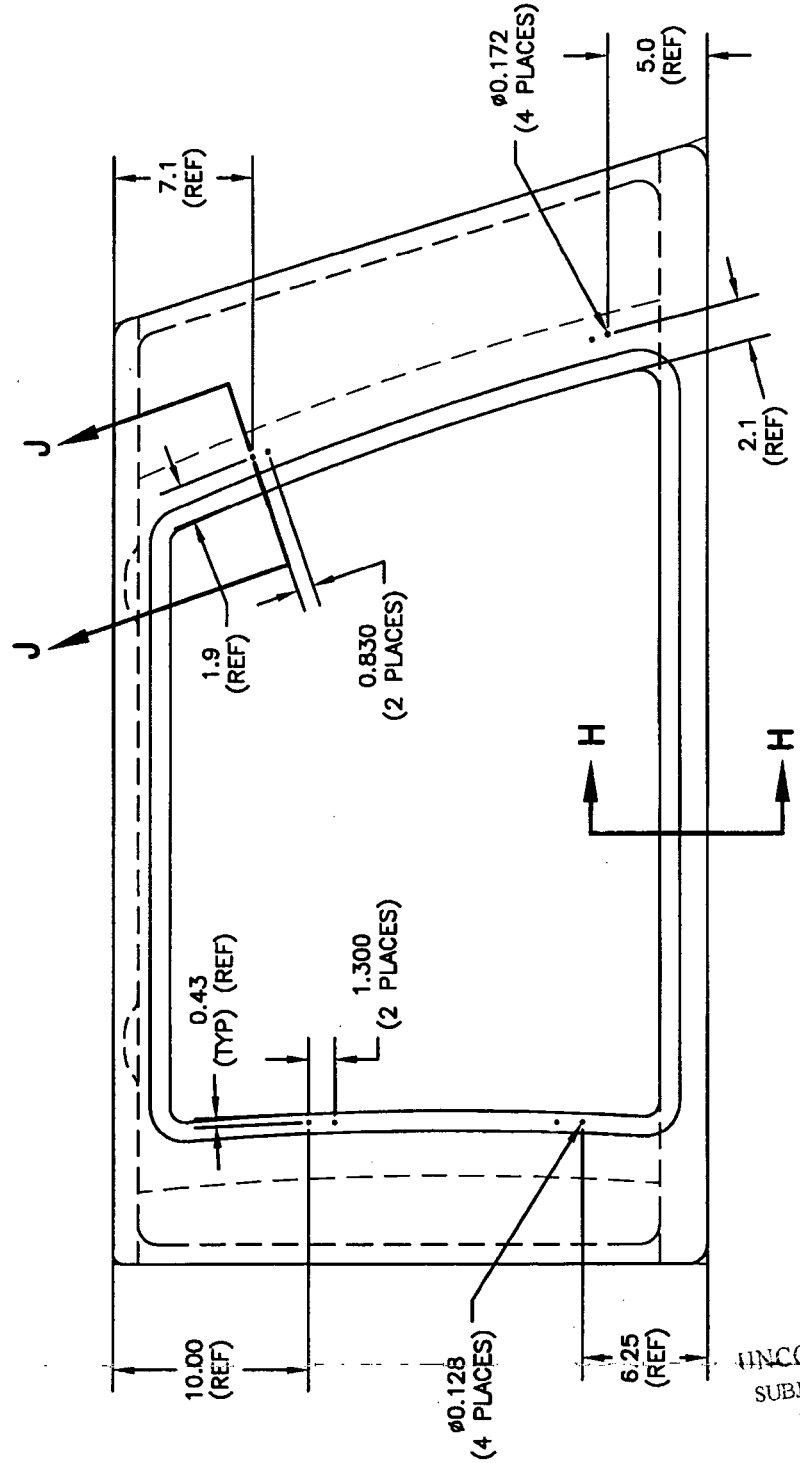
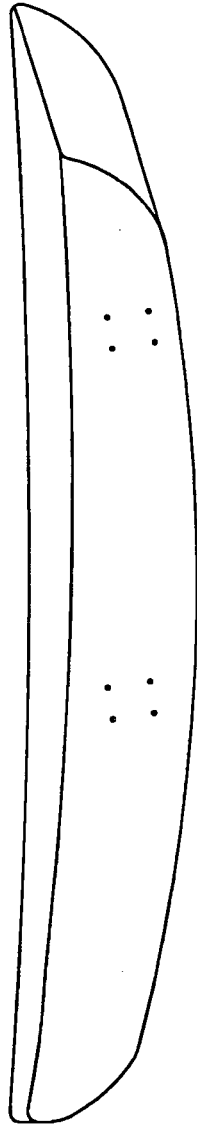
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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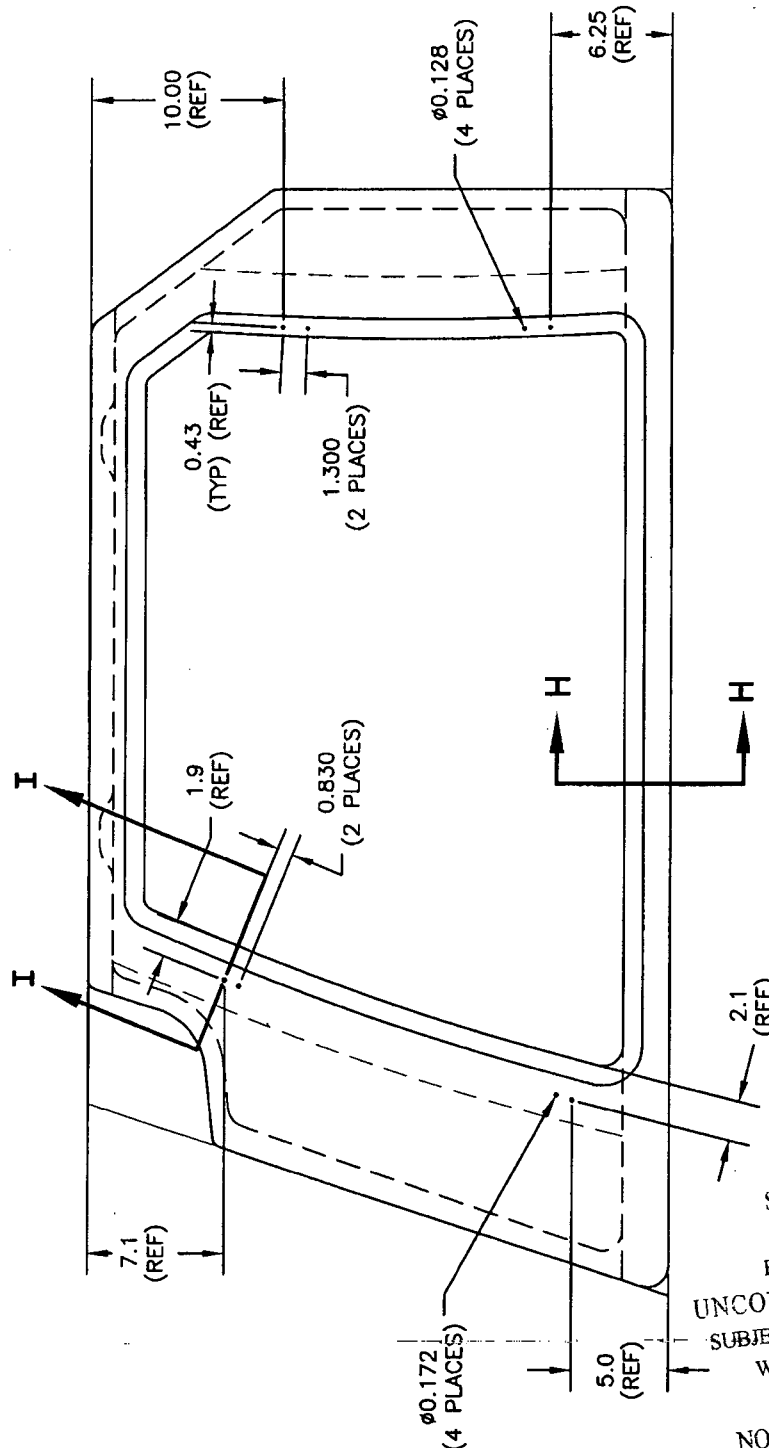
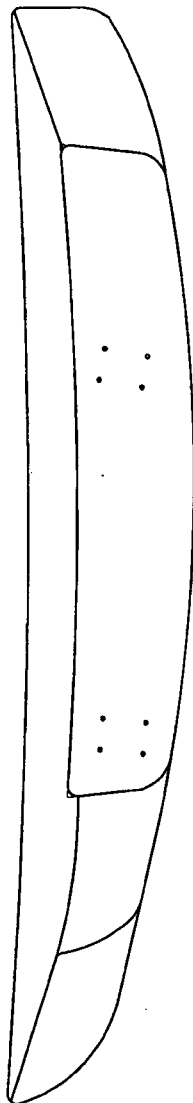
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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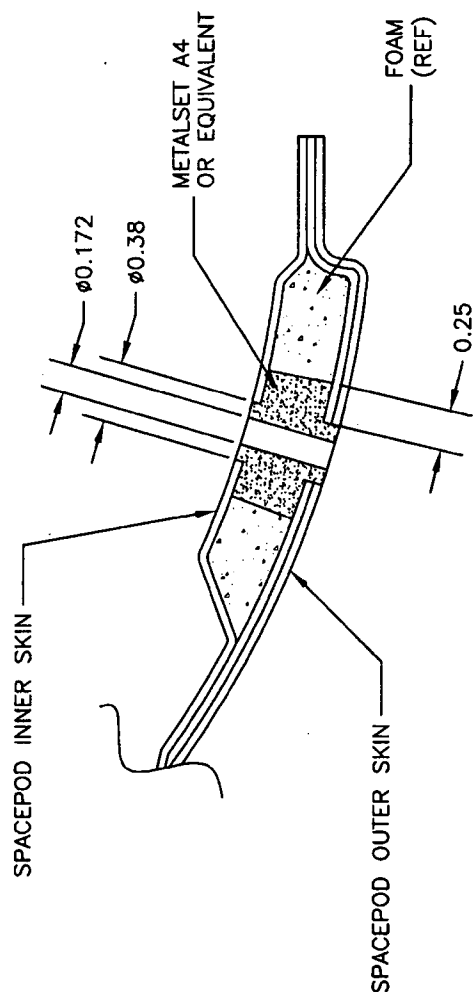
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06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

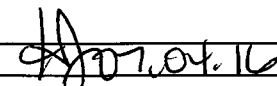
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Date: Monday, 4/16/2007 2:27:05 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY RH
Job Number	: 31770A		
Estimate Number	: 12596		
P.O. Number	:	Part Number	: D31882M
This Issue	: 4/16/2007 S.O. No. :	Drawing Number	: D3188 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 31769A	Material	:
Written By	:	Due Date	: 5/10/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec est rev C rev E dwg 07.04.16 EC		

Additional Product

w/o 30043 ml 07/05/01

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8	D2213	Spacer	Batch: _____
---	-------	--------	--------------

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
Issue P/O: _____
Description: D3188-2M BODY
SHIP: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:27:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 31770A

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07.04.02

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JB	CB	DRAWING NO.	REV. E
CHECKED CE	APPROVED [Signature]	D3188	SHEET 1 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

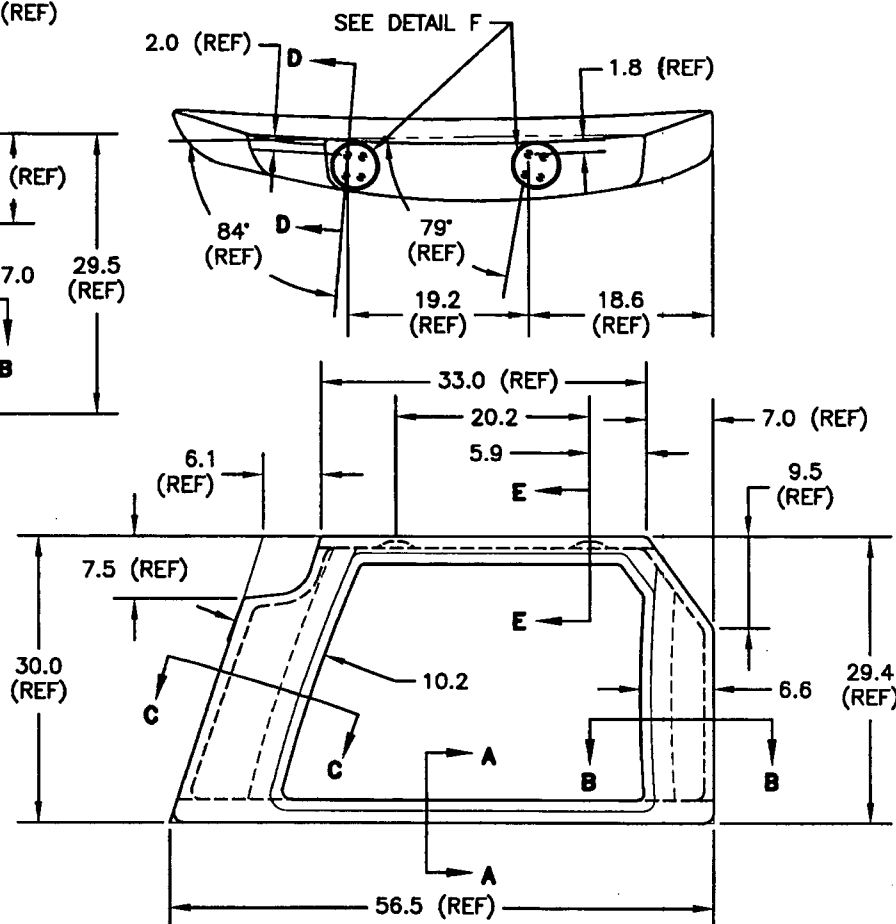
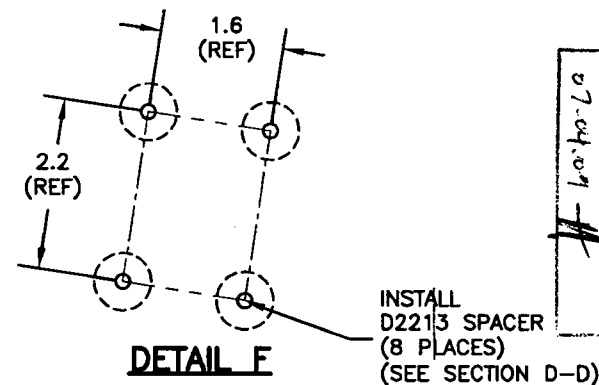
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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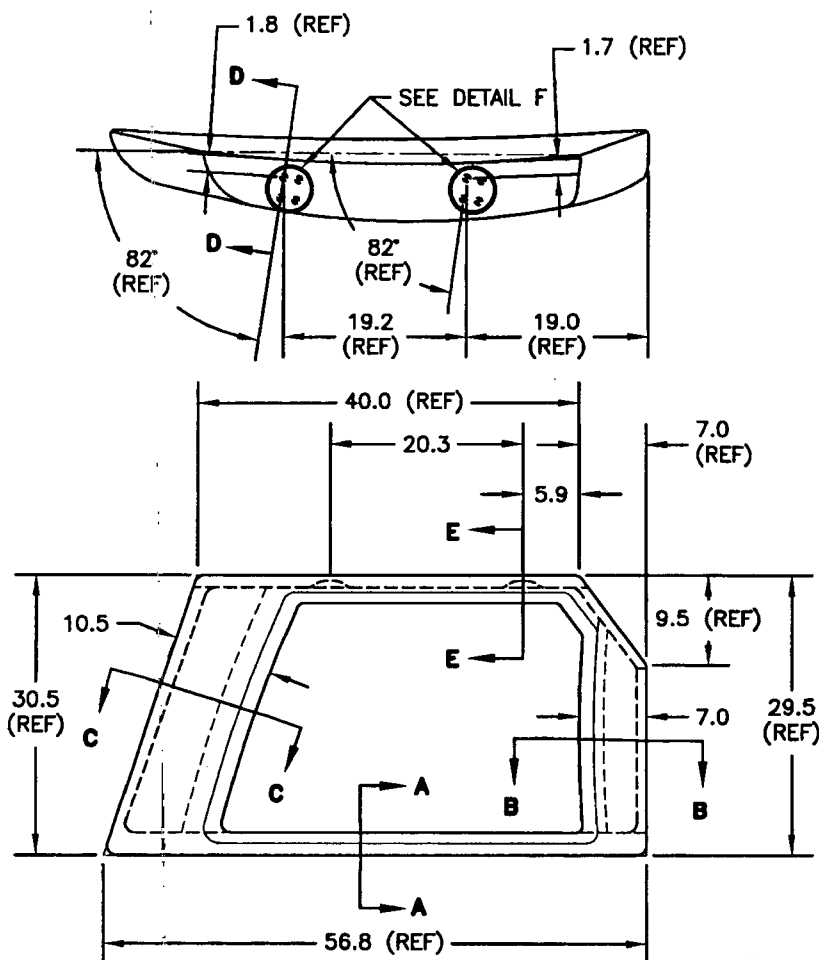
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		SCALE NTS



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

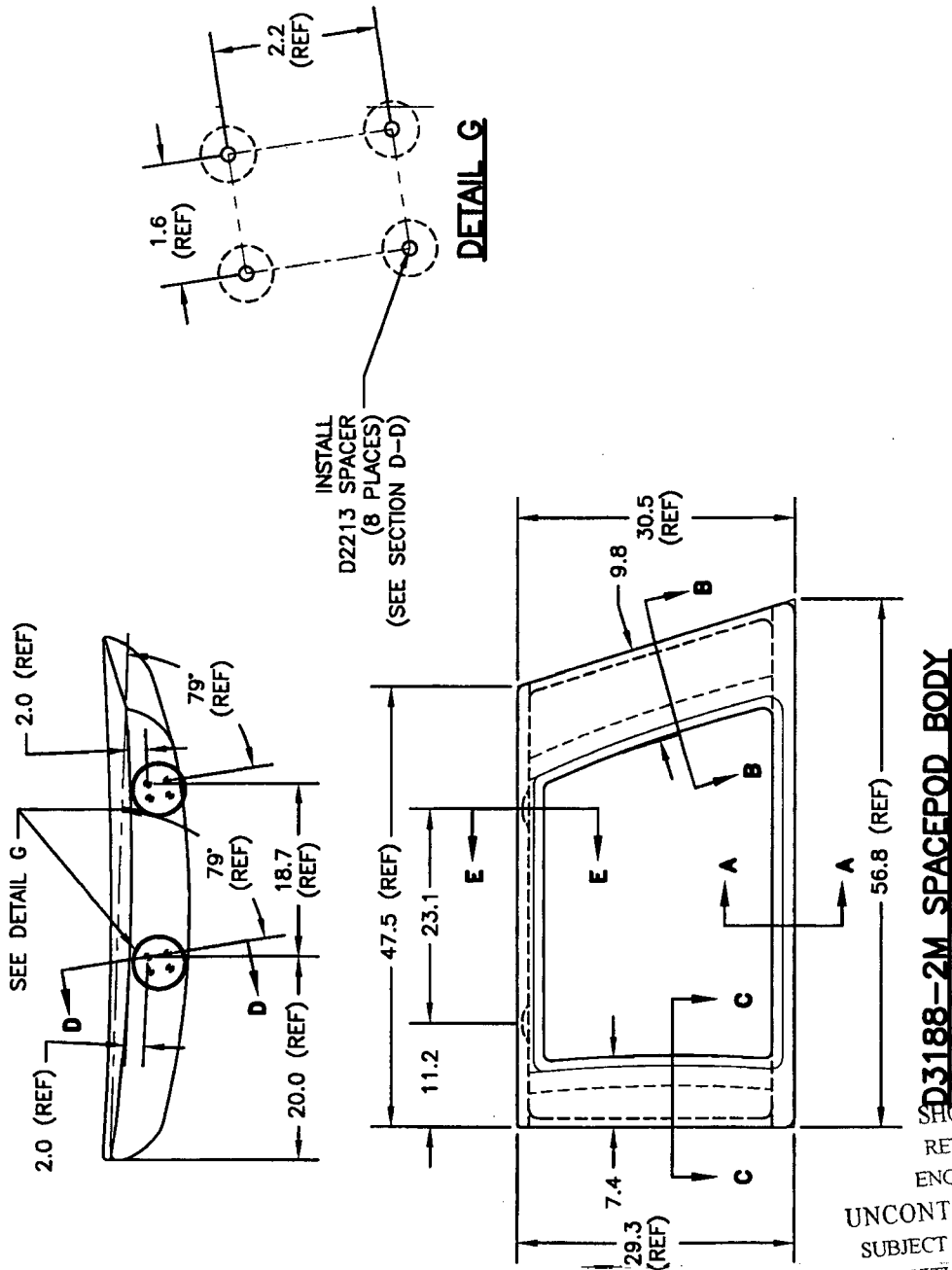
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D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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D3188-2M NOTES:
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2) SEE SHEET #4 FOR SECTION VIEWS.

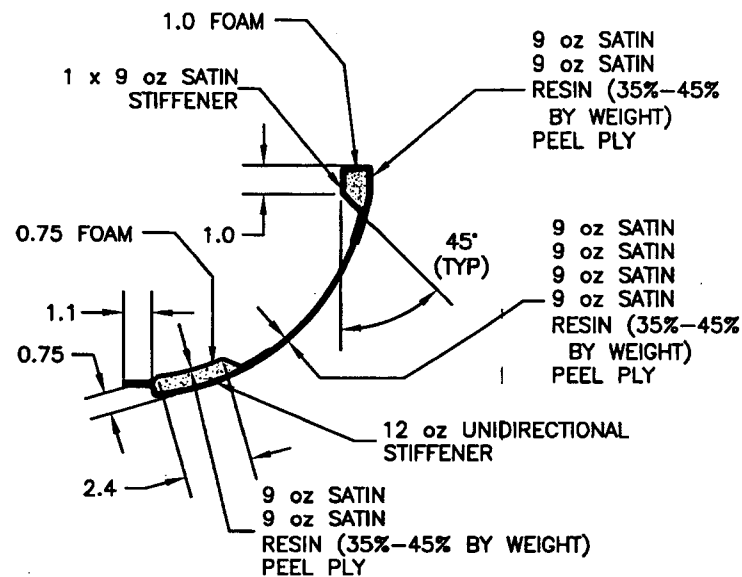
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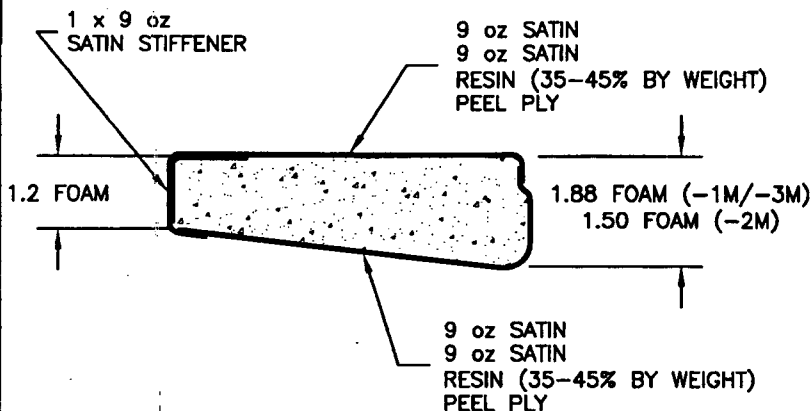
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

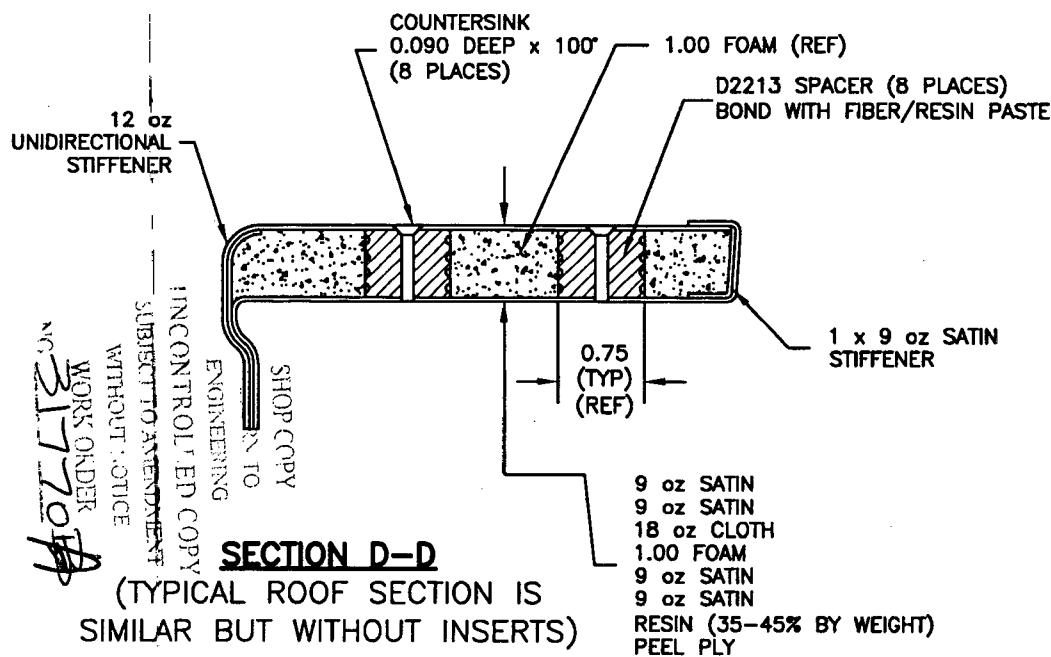
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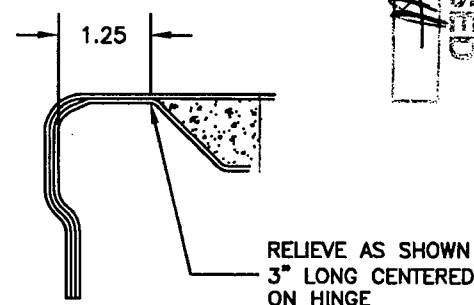
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

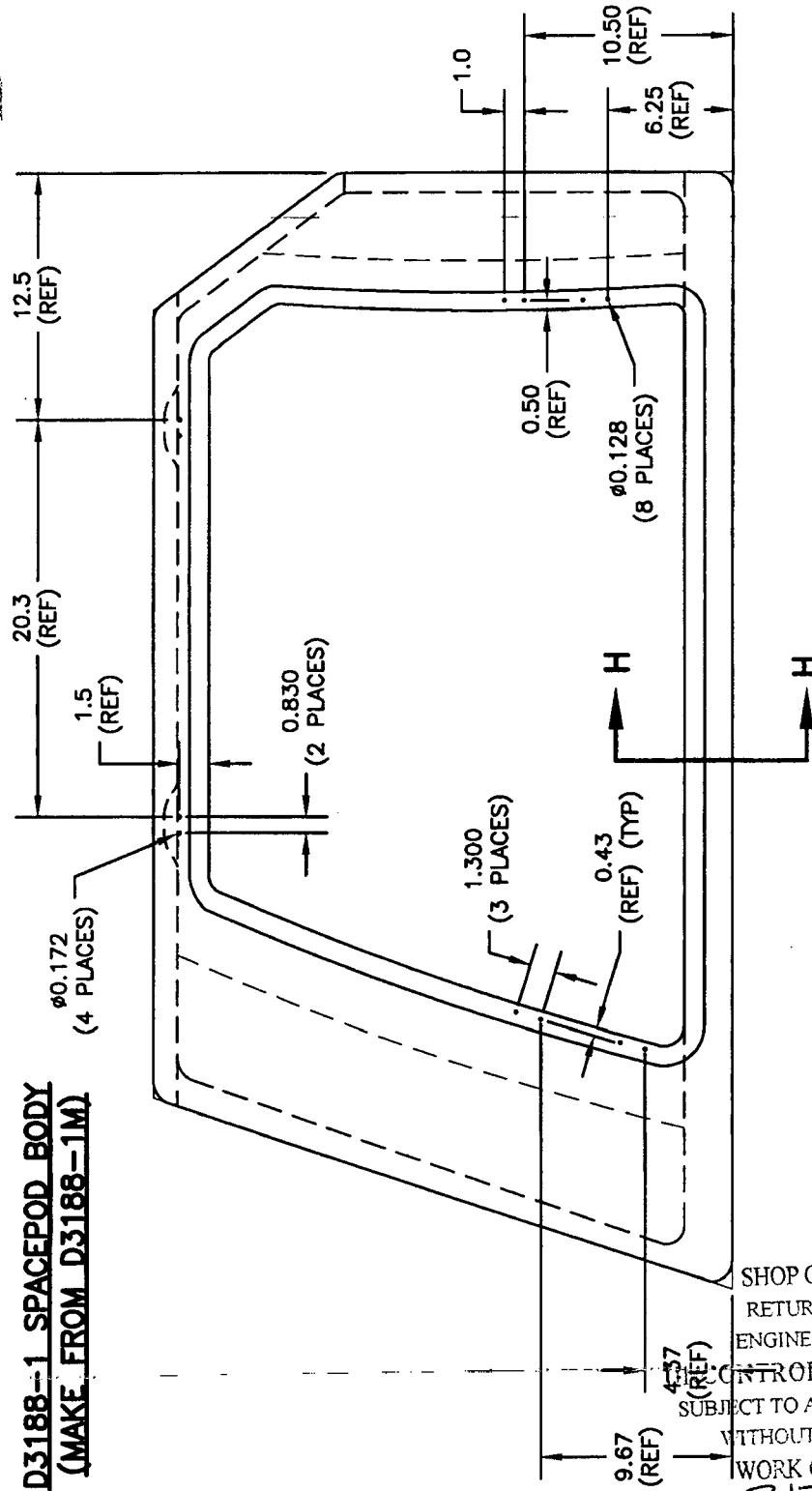
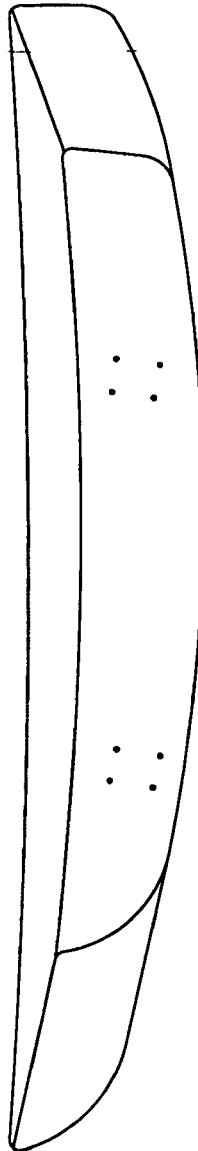
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
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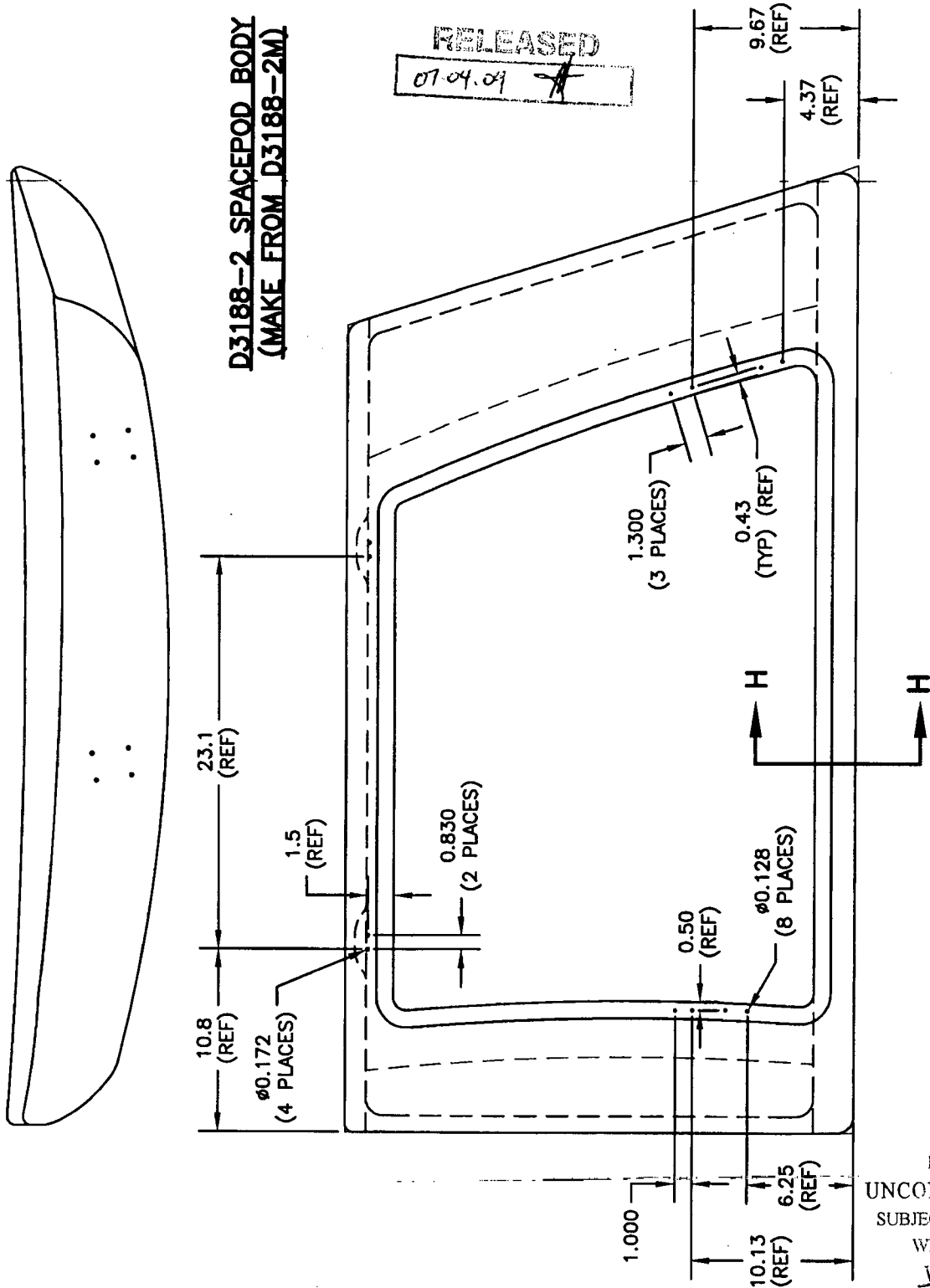
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



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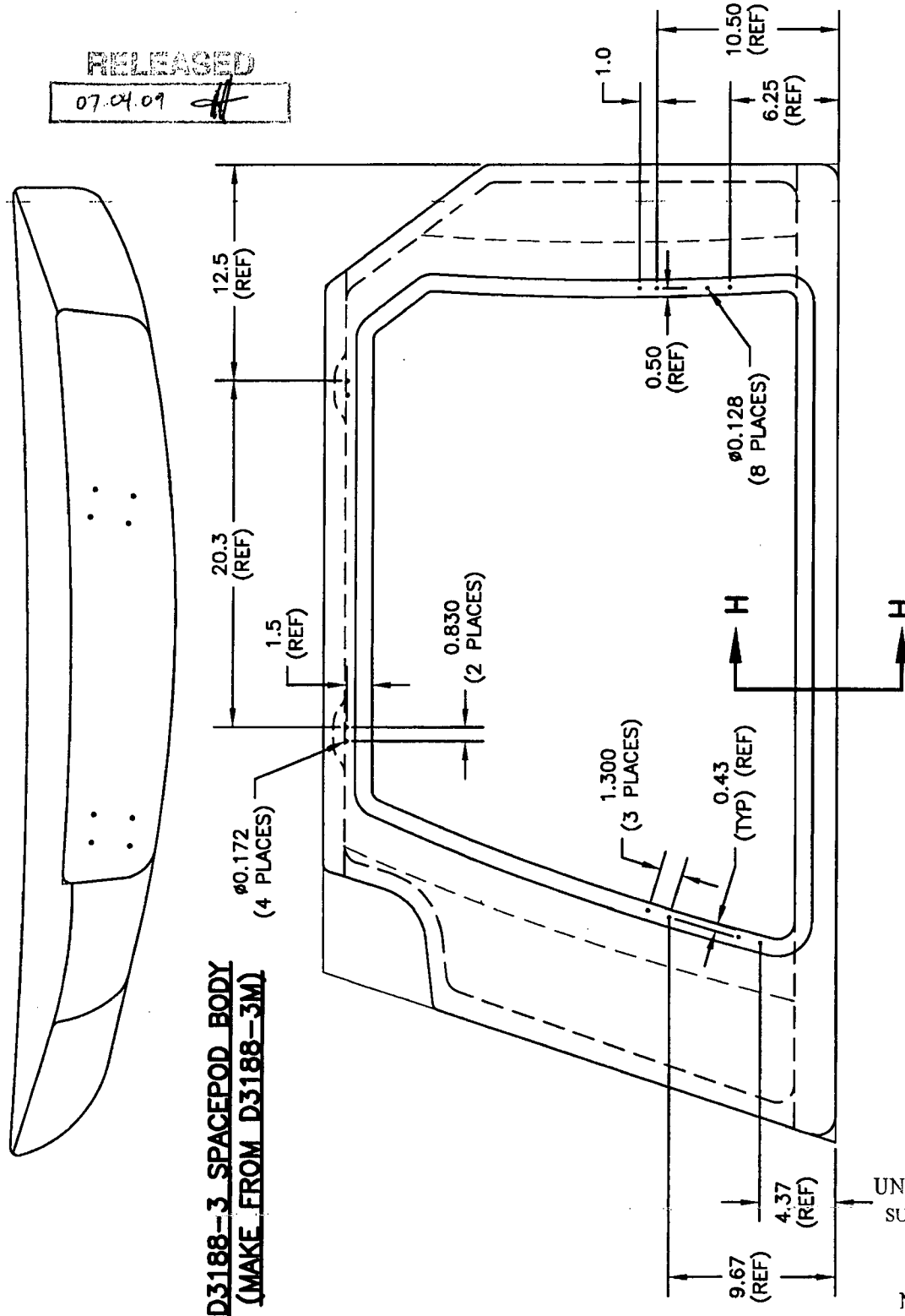
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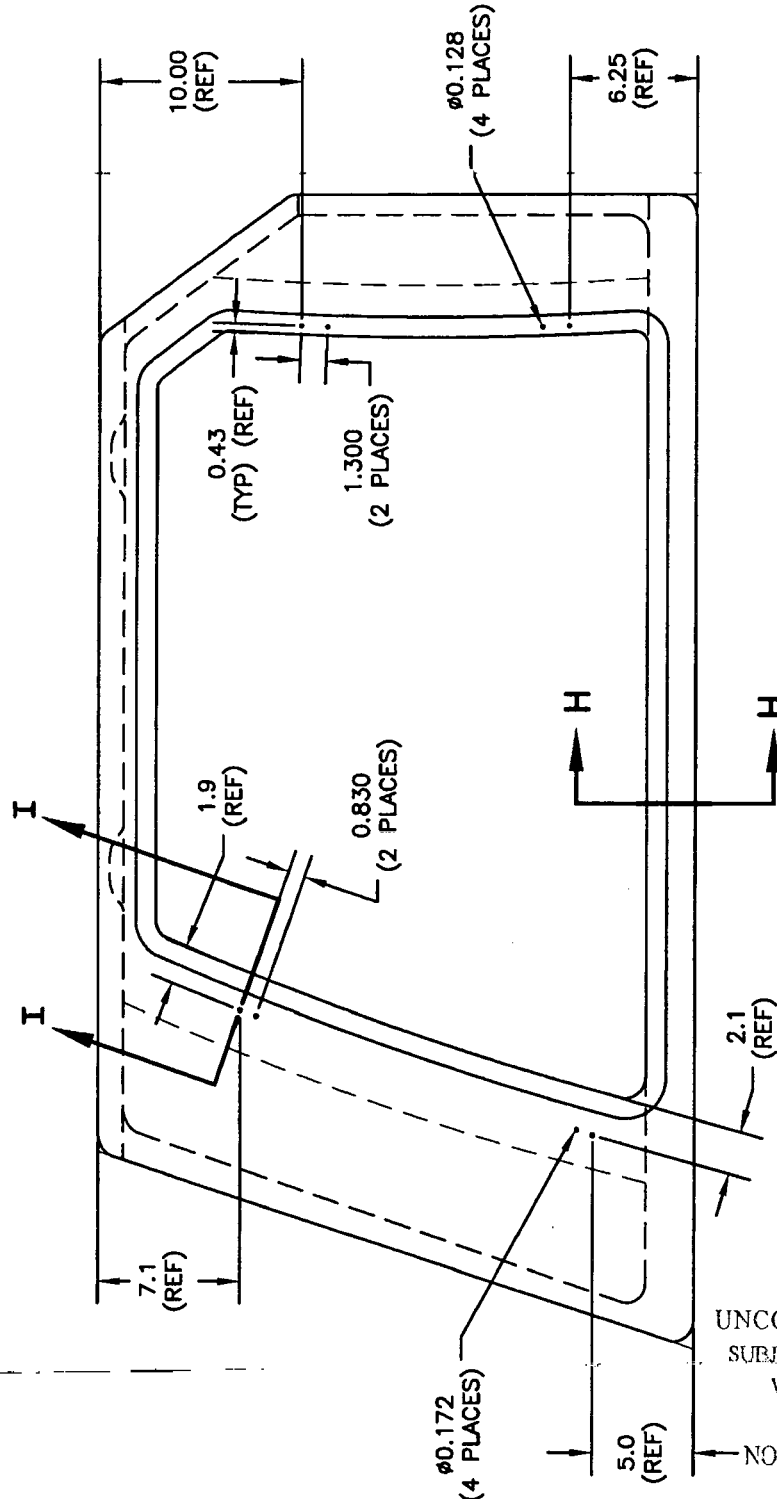
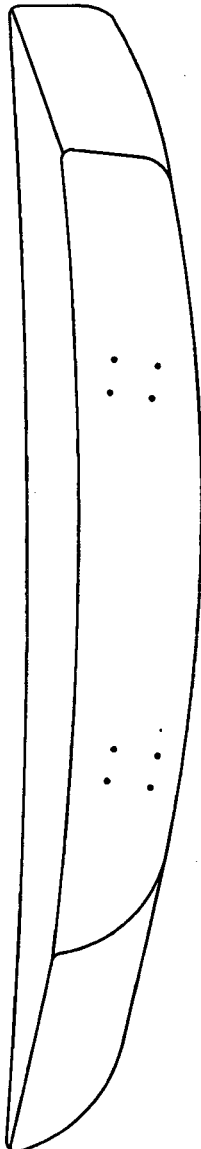
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02 **[Signature]**

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
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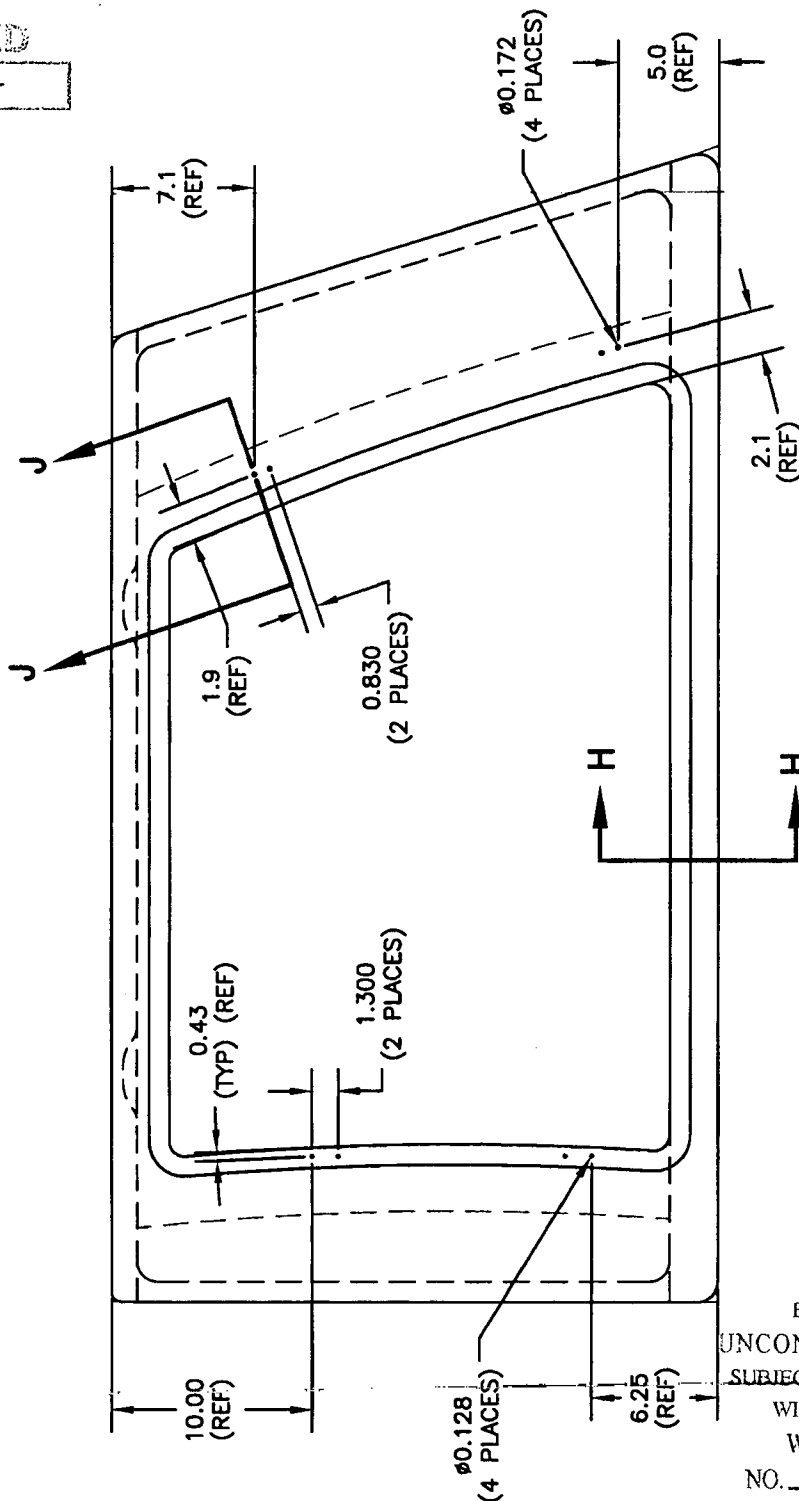
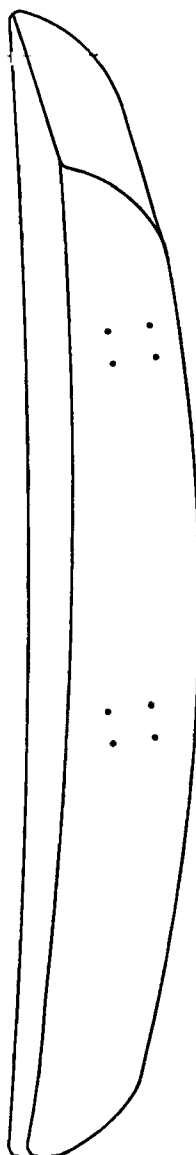
DART

DESIGN JB	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED #	DRAWING NO. D3188
DATE 07.04.02	TITLE SPACEPOD BODY	REV. E SHEET 9 OF 11 SCALE NTS

RELEASED

07.04.09

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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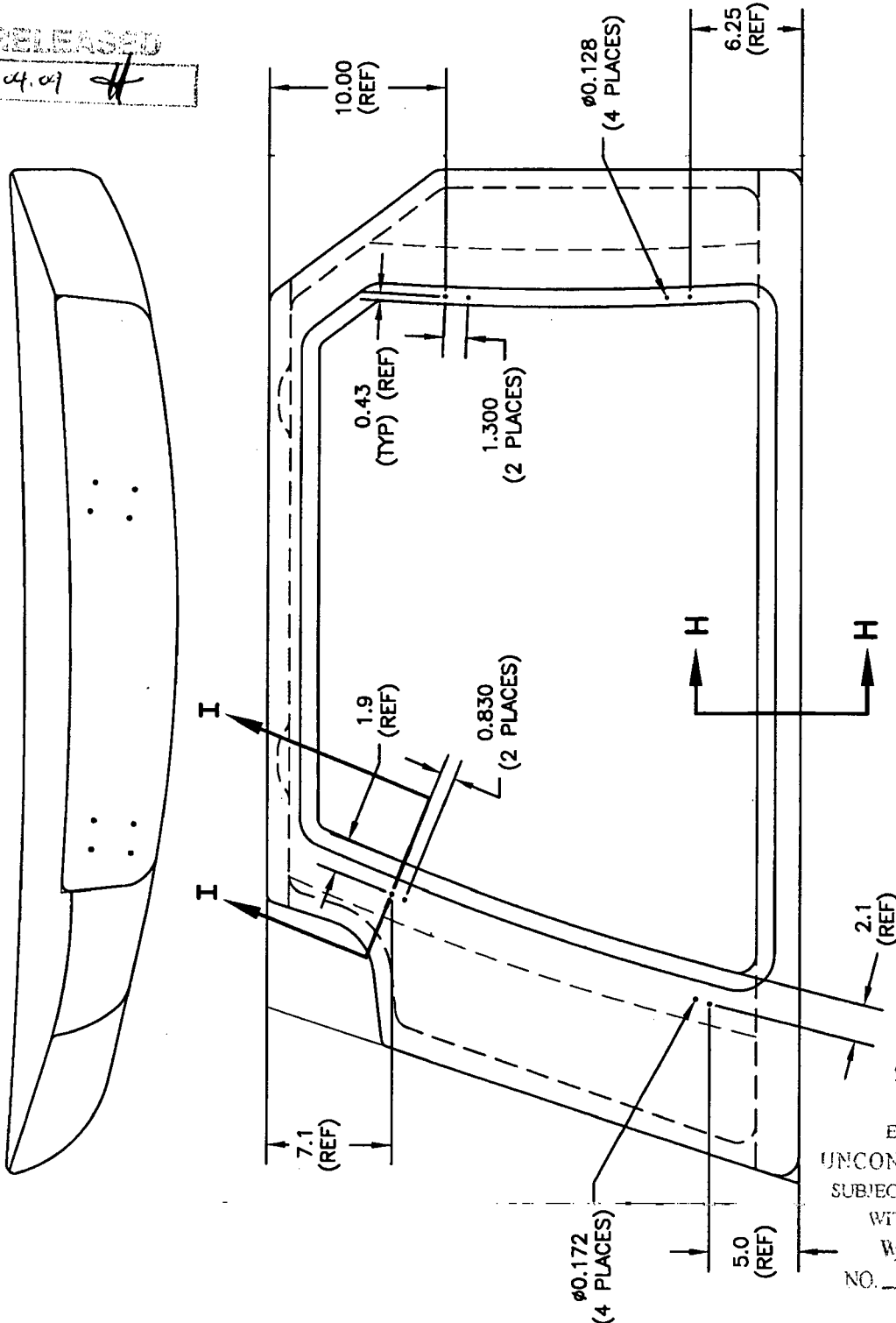
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3188	REV. E SHEET 10 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



- NOTE:**
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 11 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

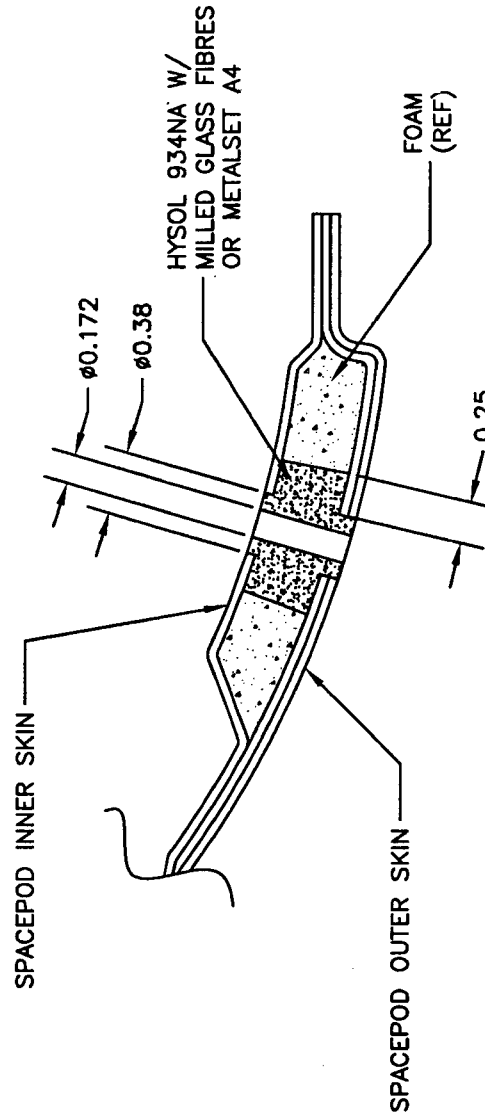
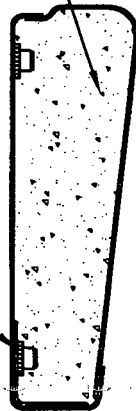
RELEASED

01.04.09 **[Signature]**

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)

SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Monday, 4/16/2007 2:27:09 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 31770B01		
Estimate Number	: 12599		
P.O. Number	:	Part Number	: D31862M
This Issue	: 4/16/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31769B01	Material	:
Written By	:	Due Date	: 5/10/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>Kim Johnston</u>		
Comment	: Est Rev:A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

Additional Product

w/o 30033

Job Number:



ml07/05/01

Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

2.0 D31862P Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

inspect dimensions as per Dwg D3186. Visual inspection. Check for void spot and pins.

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:27:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 31770B01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

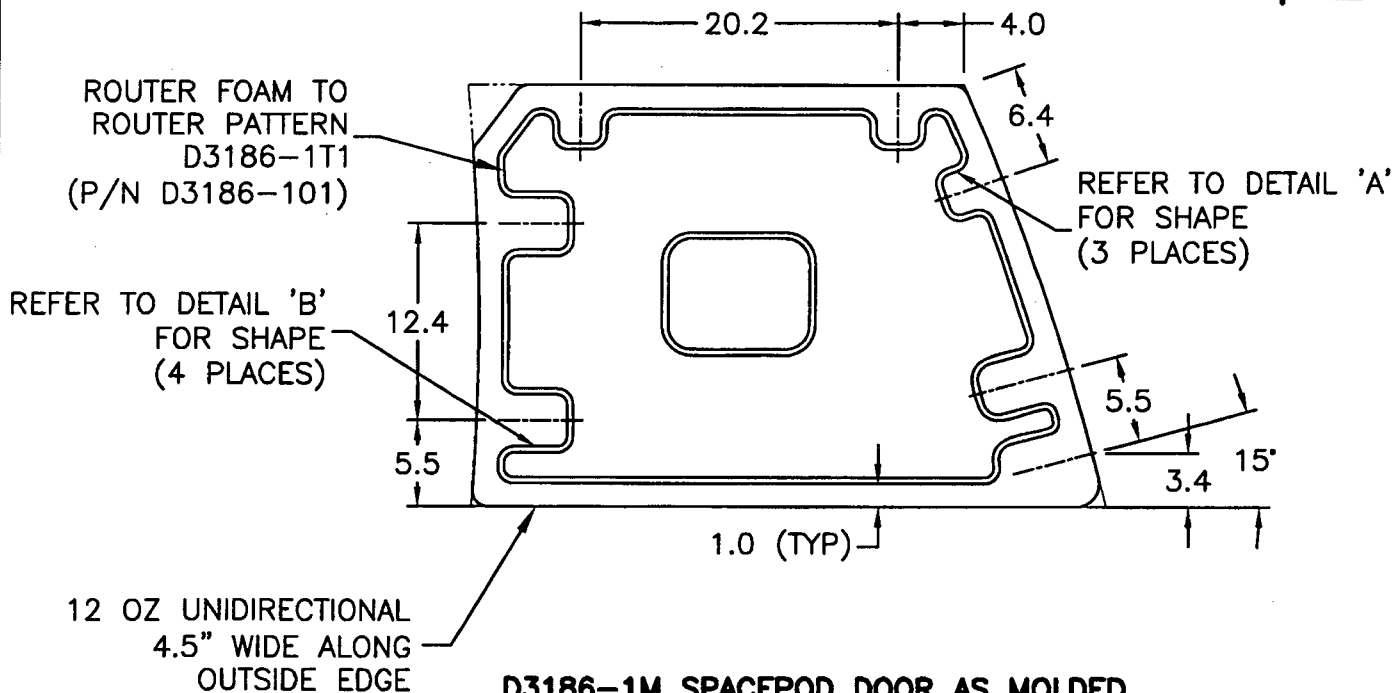
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 31770Bd

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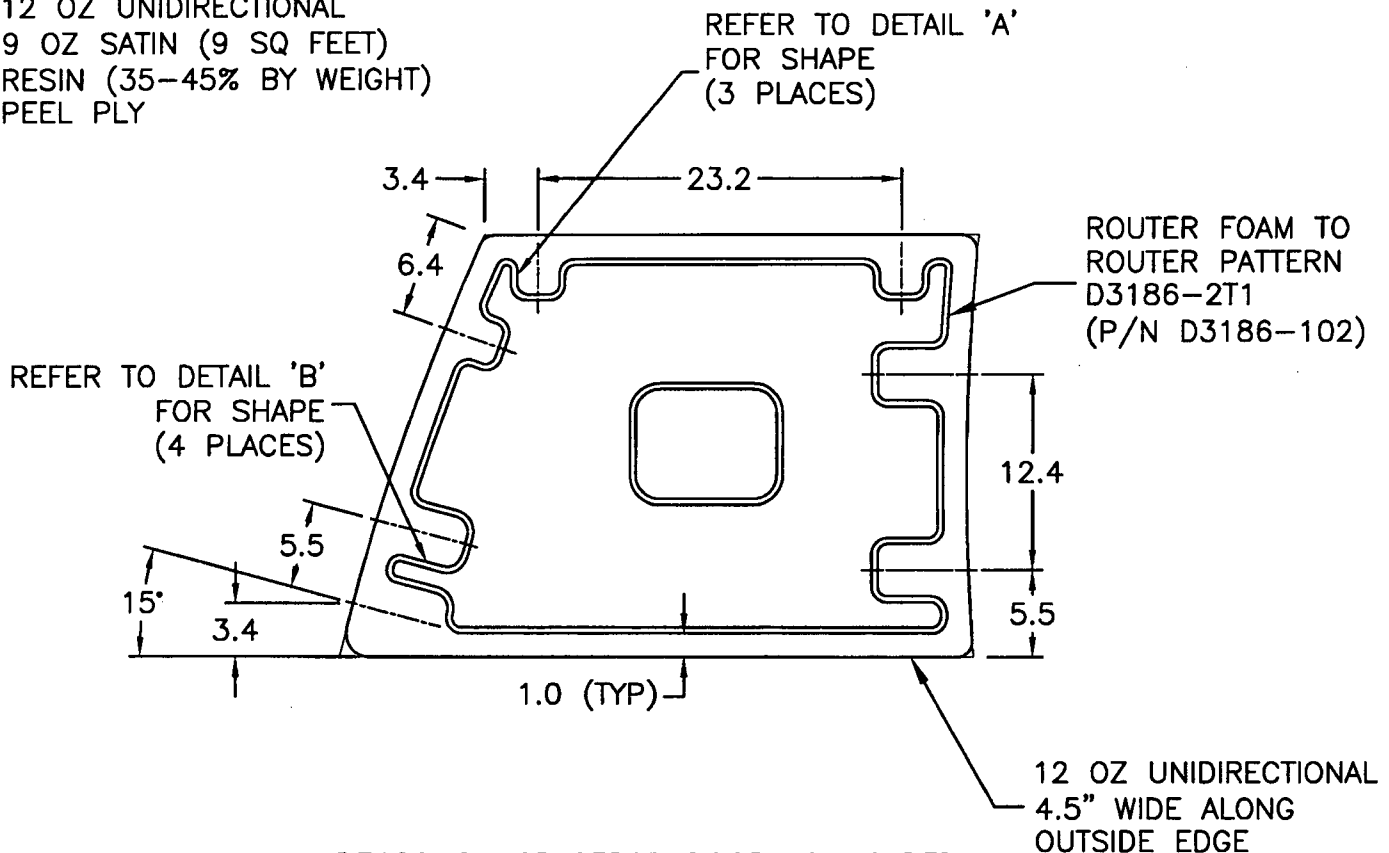
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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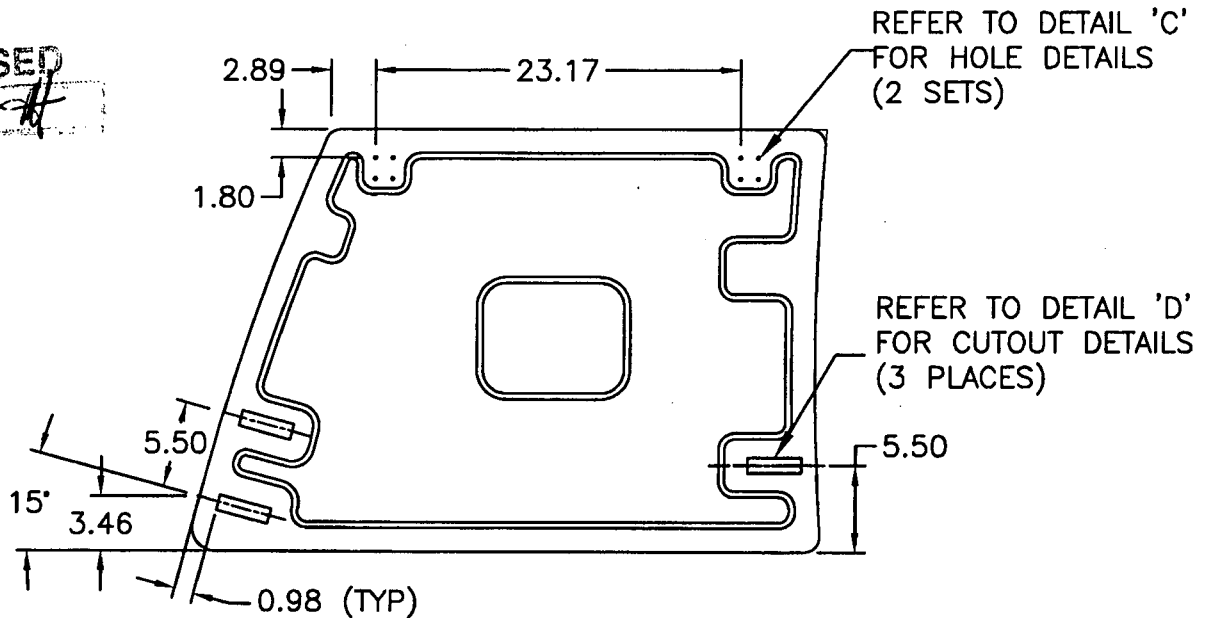
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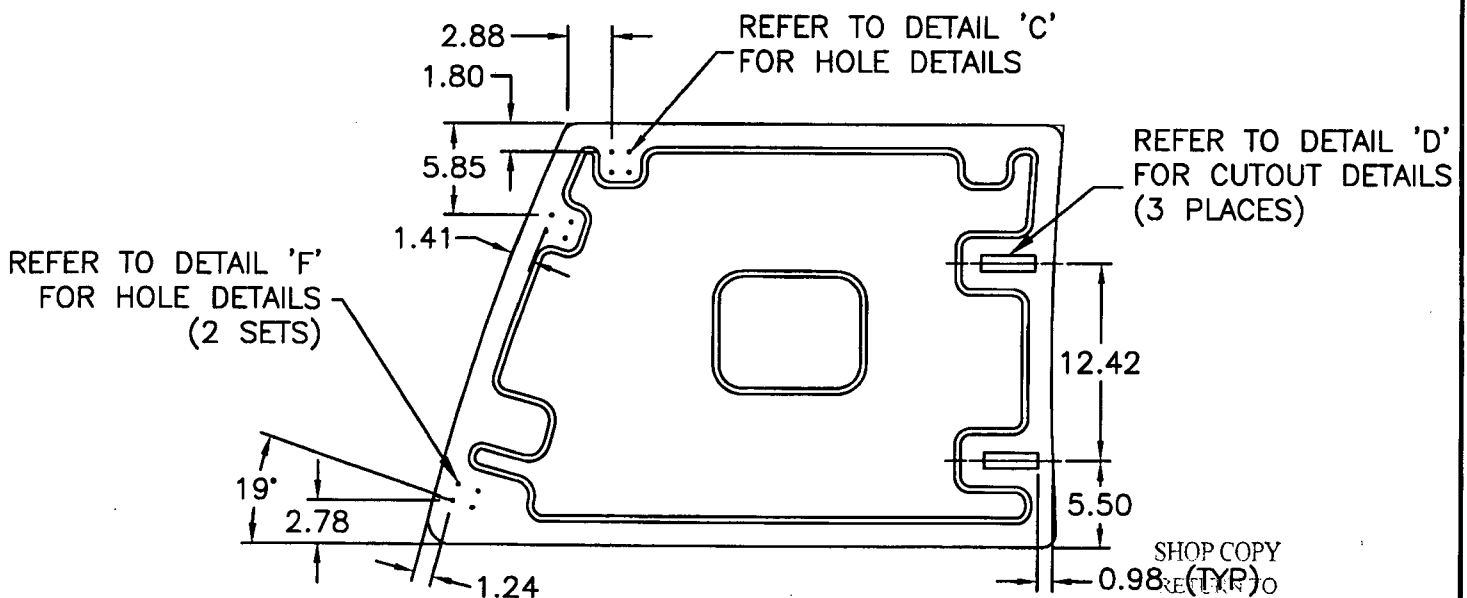
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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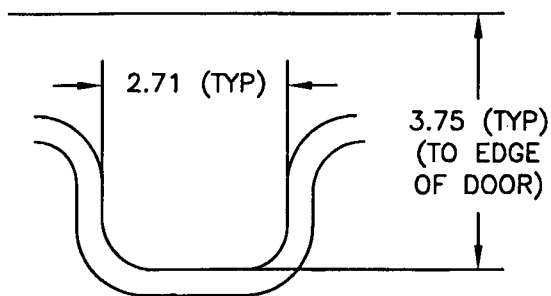
WORK ORDER
NO. 31770801

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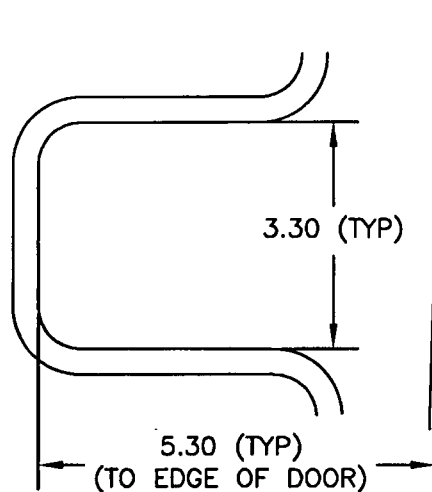
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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



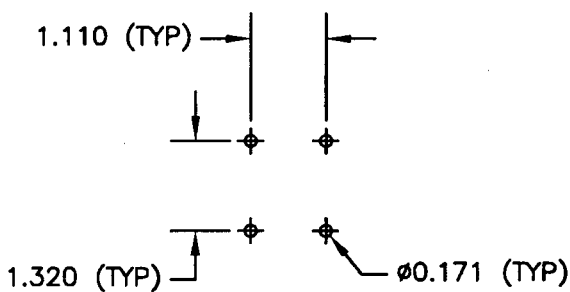
DETAIL A



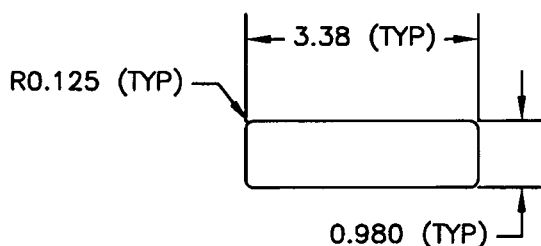
DETAIL B

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07.02.27 [Signature]

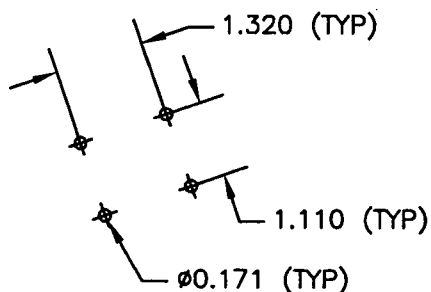


DETAIL C

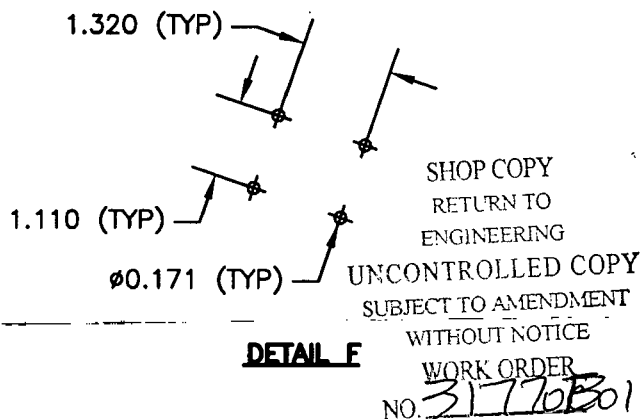


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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e: Mardi, 2007-03-06 09:23:32
 isateur: Sylvie Hamel

Feuille de Procédé

 Client : DART Dart Aerospace Ltd.
 Numéro Job : 40887
 Numéro Soumission : 2587
 Numéro B.A. :
 Cette fois : 2007-03-06 No. B.V. :
 Révisé Rev. : NC
 Rem. fois : - - Type :
 Job précédente : 40699

 Nom Dessin : SPACEPOD BODY
 Numéro Article : DKC134-0055
 Numéro Dessin : D3188
 Projet Numéro : DKC134
 Révision dessin : B
 Matériel : Fibre 7781 et Résine 411-350
 Date Dûe : 2007-02-05 Qté: 1 Udm: UNITE

 Crit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Dart Aerospace : D3188-2
 N° Delastek Composites DKC-134-0020
 N° de Projet Delastek: DK-362

 Process Sheet Rev.: 00 Création du premier à partir du
 DKC134-0020

Produit additionnel

Numéro Job:




Séq.: Machine ou Opération: Description :

 1.0 AC0303 Frekote 44NC
 Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MOULE

 Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon
 le QSI-006.

 Date: 16/03/07 Heure Début: 8:00 Heure Fin: 11:00 Sceau: 

3.0 AC0409 Tissu à délaminer Release ply B

 Commentair Qty.: 9.84 VERGE(s)/Unit Total: 9.84 VERGE(s)
 Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

 Commentair Qty.: 9.27 VERGE(s)/Unit Total: 9.27 VERGE(s)
 Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

 Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)
 Feutre de drainage N° Airweave N 10

ite: Mardi, 2007-03-06 09:23:32
lisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)
Stretchlon 200 poche à vide Vert

7.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-6030-1

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5455

9.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)
WR1850 ROVING 18 OZ x 50" N° de Lot: 1-5873-1

10.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 14/03/07 Heure Début: 8:00 Heure Fin: 10:00 Sceau:

12.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 3921

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6032-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5562-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

ite: Mardi, 2007-03-06 09:23:32
illseateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Faire la préparation de la résine selon les quantités requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: 19/03/07 Heure Début: 12:30 Heure Fin: 1:00 Sceau:



16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 19/03/07 Heure Début: 1:00 Heure Fin: 1:50 Sceau:



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 19/03/07 Heure Début: 1:50 Heure Fin: 2:10 Sceau:



Curing Début: 2:00 PM Curing Fin: 8:00 AM

te: Mardi, 2007-03-06 09:23:32
lisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description:

18.0 AAC0457 ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

19.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run: 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler le Foam Core 1" selon le plan de découpe et les gabarits

Date: 2/03/07 Heure Début: 8:00 Heure Fin: 10:00 Sceau:



20.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6632-1

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total: 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5721

22.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
FINITION PIÈCE DART

22/03/07



Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le
Foam Core.

23.0 AAC0452 Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total: 0.010 KIT(s)
Polybond B46F

N° de Lot: 1-5865-1

24.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
FINITION PIÈCE DART

À l'aide du Polybond, coller ensemble les deux surfaces scellées

ate: Mardi, 2007-03-06 09:23:32
utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Disposer des poind sur les pièces pour conserver une pression de collage.

Laisser sécher pour un minimum de deux heures.

Quantité: 1 Date: 22/03/07 Sceau:



Quantité: Date: Sceau:

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster chacune des pièces de foam core dans le moule selon de lessin.

Quantité: 1 Date: 23/03/07 Sceau:



Quantité: Date: Sceau:

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs
PRÉPARATION DU MATÉRIEL DART

23/03/07



Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350 promué 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs
FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promué N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.

ite: Mardi, 2007-03-06 09:23:32
ilisateur: Sylvie Hamel

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Laisser sécher pendant 2 heures minimum.

Date:

23/03/07

Sceau:



Initiales:



30.0 AAC0452

Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 5979

31.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.

Date:

26/03/07

Heure Début:

12:00

Heure Fin:

1:00

Sceau:



32.0 ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date:

26/03/07

Heure Début:

1:00

Heure Fin:

1:40

Sceau:



33.0 POCHÉ À VIDE 1

FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date:

26/03/07

Heure Début:

1:40

Heure Fin:

2:00

Sceau:



Curing Début:

2:00

Curing Fin:

3:15

ite: Mardi, 2007-03-06 09:23:32
Ilisateur: Sylvie Hamel

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

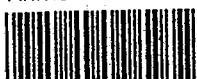
Commentair Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6005-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond

Date: 28/03/07 Heure Début: 12:30 Heure Fin: 2:30 Sceau: 32



37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

28/03/07



38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total: 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

39.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0032 PINTE(s)/Unit Total: 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

40.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core

Laisser sécher pendant minimum deux heures.

28/03/07



ate: Mardi, 2007-03-06 09:23:32
utilisateur: Sylvie Hamel

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTÉ(s)/Unit Total: 0.0504 PINTÉ(s)
Catalyst N° DDM-9

N° de Lot:

5921

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6032-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date:

29/03/07

Heure Début:

12:30

Heure Fin:

1:00

Sceau:



44.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date:

29/03/07

Heure Début:

1:00

Heure Fin:

1:50

Sceau:



45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

ate: Mardi, 2007-03-06 09:23:32
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 29/03/07 Heure Début: 1:50 Heure Fin: 2:10 Sceau: DELASTEK COMPOSITES 62

Curing Début: 2:10 PM Curing Fin: 8:00 AM



46.0 DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 4/04/07 Heure Début: 4:15 Heure Fin: 4:30 Sceau: DELASTEK COMPOSITES 65

47.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Perçer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, perçer les 8 dégagement de $\varnothing .745"$ pour les spacers N° D2213 (ne pas perçer la peau extérieure de la pièce)

Date: 5/04/07 Heure Début: 12:30 Heure Fin: 2:00 Sceau: DELASTEK COMPOSITES 65

48.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

49.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. 15 min

N° de Lot: 1-6024-1

50.0 AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

atq: Mardi, 2007-03-06 09:23:33
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:




Séq.: Machine ou Opération: Description :

51.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 6/04/07 Heure Début: 8:00 Heure Fin: 8:15 Sceau: 

52.0 AAC0448 Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s)
Spacer N° D2213 N° de Lot: 1-5949-1

53.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART




Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer un pression sur les pièces de 9 ox à l'aide d'un bloc de bois et de pinces autoblocantes

Laisser sécher pendant 4 heures minimum.

Date: 6/04/07 Heure Début: 8:15 Heure Fin: 9:00 Sceau: 

Curing Début: 9:00 Curing Fin: 12:30

54.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921





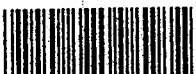





55.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40887		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
56.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			
Date: <u>10/04/07</u> Heure Début: <u>16:15</u> Heure Fin: <u>10:20</u> Sceau: 			
57.0	LAMINAGE.	LAMINAGE PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs FAIRE LE LAMINAGE DES TISSUS			
Retirer les pinces et blocs de bois			
Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièces. Selon le dessin.			
Laisser sécher pendant 4 heures minimum.			
Date: <u>10/04/07</u> Heure Début: <u>16:20</u> Heure Fin: <u>12:00</u> Sceau: 			
Curing Début: <u>12:00</u> Curing Fin: <u>8:00 AM</u>			
58.0	FINITION 3	FINITION PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART			
Repercer les 8 trous des spacers afin de les déboucher			
Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections. <u>11-4-07</u> 			
59.0	AAC0671	Dupont Primer N° 1104S	
Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s) Dupont Primer N° 1104S			
N° de Lot: <u>1-5931-2</u>			
60.0	AAC0670	Dupont Activator N° 7975S	
Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s) Dupont Activator N° 7975S			
N° de Lot: <u>1-6041-1</u>			

Date: Mardi, 2007-03-06 09:23:33
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: 1-5390-2

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

APR 11 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer une couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer

Laisser sécher pendant 3 heures minimum

Date: APR 11 2007

Heure Début: _____ Heure Fin: _____ Sceau: _____



64.0 AAC0451 Label N° D0600-142

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0600-142 N° de Lot: _____

65.0 AAC0444 Surface Veil

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)
Surface Veil N° de Lot: _____

66.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)
Résine Mia-Poxy N° de Lot: _____

N/A



67.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total: 0.030 PINTE(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: _____

68.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-142 sur le spacepod en plaçant un surface veil eu dessous et par dessus le label à l'aide de résine Mia Pox. Selon I.F. # DKC134-0019-13

Date: Mardi, 2007-03-06 09:23:33
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40887

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: _____ Heure début: _____ Heure fin: _____ Sceau: _____

69.0 AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6044-1

70.0 AC0059

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

71.0 FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide du Sikkens

Faire un léger sablage (Grit 220) de toute les surfaces.

Date: 12-4-07 Heure Début: _____ Heure Fin: _____ Sceau: _____

72.0 AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5931-8

73.0 AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6041-1

74.0 AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5390-2

75.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Masquer le label.

APR 12 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40887

Numéro Article: DKC134-0055

Numéro Job: --



Séq.: Machine ou Opération: Description :

76.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
APPLICATION DE PRIMER

Appliquer deux couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.

Laisser sécher pendant 3 heures minimum

Date: 12 2007

Heure Début: _____

Heure Fin: _____

Sceau: _____



77.0

INSPECTION 3

INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 13-4-07

Sceau: _____



Initiales: _____

78.0

EMBALLAGE 3

EMBALLAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.

Quantité: _____

Date: 13/4/07

Sceau: _____



Quantité: _____

Date: _____

Sceau: _____



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11860
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #		GST/PST #
20/04/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30013 Dwg. Rév.: C Job: 41317			
				U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30023 Dwg. Rév.: C Job: 41111			
				U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30033 Dwg. Rév.: C Job: 41326			
				U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30043 Dwg. Rév.: C Job: 40887			
				U de M : Each			

ml 07/05/01

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

DELASTEK
COMPOSITES
GA